

NONDESTRUCTIVE TESTING

2014 CATALOG

Reference Standards
Calibration Blocks

for the **NDT INDUSTRY**

Power Generation
Manufacturing
Aerospace
Research
Transportation
Aircraft
Petrochemical
Naval
Medical
Primary Metals



PH TOOL
REFERENCE STANDARDS

The STANDARD of Excellence



About the Company...



PH Tool Reference Standards, headquartered in Pipersville PA, has supplied the NDT industry with high quality Reference Standards and Test Blocks since its founding in 1973. Whether you need EDM notches, Flat-bottom holes, Micro-holes or Test Blocks, PH Tool can handle your order. We are a family-managed business, founded by Phil Herman Sr. In 1990 Phil Herman Jr. joined the business and serves as President/CEO. The entire staff is dedicated to the development and fabrication of the finest quality reference standards available today. Our growth and high degree of product acceptance can be attributed to our emphasis on quality, attention to detail and innovative approaches to meeting the reference standard needs of our valued customers.

Our Reference Standards and Test Blocks are used in ultrasonic, eddy current, magnetic particle, liquid penetrant and radiographic testing. Reference Standards can be fabricated from customer-supplied pipe, tube, bar, plate or actual parts. Twenty-four hour and forty-eight hour RUSH service is available on many standards. We will supply the material to your specifications if needed.

Standard Test Blocks are available from stock in steel, stainless steel and aluminum for immediate shipment. Test Blocks in exotic alloys are also available, including: alloy steel, stainless steel, inconel, titanium, copper-nickel, NAB, monel, hastelloy and others.

Specials can be fabricated to your design by our fully-equipped CNC machine shop. All Test Blocks are permanently engraved with the block description, material and serial number. Artwork and logos can be laser engraved on our blocks.

The QA Program meets all industry and government specifications. We are nuclear industry (NUPIC) and Navy approved, and listed as the suggested vendor in several Alert Service Bulletins (ASB) including Bell Helicopter, Boeing and McDonnell Douglas. All Reference Standards and Test Blocks are delivered with an automated Certification Report providing NIST traceability. Replicas of EDM notches are archived at PH Tool and are available if needed.

This catalog identifies all of the standard test blocks available, as well as many of the popular EDM notch and Flat-bottom hole Reference Standards used in industry today. In addition, you'll find information on other services including recertification of existing standards, custom machined ultrasonic wedges and radius/angle gages.

Throughout our history, PH Tool has earned an excellent reputation with our customers for supplying the best Reference Standards and Test Blocks available. Our manufacturing and technical support staff are always prepared to assist the NDT engineer or technician with their Reference Standard needs. Meeting the demands of the increasingly complex and quality-conscious NDT marketplace is a challenge we gladly accept. We welcome your inquiries and look forward to serving you.



Contents

EDM Notch Information Sheet

Nano Notch Information Sheet

What is EDM?

Explanation of EDM and Advantages	1
---	---

Basic Notch Shapes

Square Notch.....	1
U-Notch.....	1
V-Notch.....	1
Nano Notch	1

Holes, Flat-bottom and Other

Flat-bottom hole.....	2
Side-drilled hole.....	2
Micro-sized hole	2
Concave Radius-bottom hole.....	2
Convex Radius-bottom hole	2
Irregularly-shaped pits	2

Ultrasonic Test Blocks

IIW-Type 1 Block	3
IIW-Type 2 Block	3
DC Block	3
SC Block	3
DSC Block	3
DS Block.....	3
4-Step Block.....	4
5-Step Block.....	4
Type MAB Miniature Angle Beam Calibration Block.....	4
IOW Beam Profile Block.....	4
AWS Resolution Block.....	4
NAVSHIPS Test Block.....	4
Miniature Resolution Block.....	5
30 FBH Resolution Block.....	5
ASME N-625 Reference Plate	5
Miniature IIW-Type 2 Block	5
V1/5 (A2) Calibration Block	5
V2 (A4) Calibration Block.....	5
90° Curved 5-Step Block	6
VW Step Block	6
Thin Step Block	6
Magna-Thin Step Block.....	6
10-Step Block.....	6
Tipsy Step Block including the “Universal” Tipsy Block.....	6

Ultrasonic Test Blocks (continued)

EDM Slot Sizing Block	7
“FAST” UT Sizing Block.....	7
PACST TM Block.....	7
Mini PACST TM Block.....	7
PACST TM Notch Block.....	7
Phased Array Calibration Block No. 2	8
Phased Array Type A Block (IIW-Type)	8
ASTM E2491 Phased Array Assessment Block	8
Phased Array NAVSHIPS Block	8
ASTM Area Amplitude Set of 8.....	9
ASTM Distance/Area Amplitude Set of 10.....	9
ASTM Distance Amplitude Set of 19	9
ASTM Single Blocks.....	9
ASTM Specials.....	9
Westinghouse Reference Standards.....	9
ASTM E317 Horizontal and Vertical Linearity Block, Fig. 1	10
ASTM E317 Resolution Block, Fig. 6	10
ASTM E1158 Distance Amplitude Blocks	10
ASTM E1158 Area Amplitude Blocks.....	10
MIL-STD-2154 UT Test Blocks	10

Ultrasonic Calibration Blocks and Standards

ASME Sec. V Basic Calibration Block.....	11
ASME Sec. V Basic Calibration Block—Long Version.....	11
ASME Sec. V Angle Beam Calibration Block	11
ASME Sec. XI Basic Piping Calibration Block	11
ASME Sec. III NB-2552.3 Standards.....	11
PDI Contoured Calibration Blocks for DM welds	12

Test Block Recertification

Test Block Recertification.....	12
---------------------------------	----

Ultrasonic Reference Standards

2-Notch Pipe Standard.....	13
4-Notch Pipe Standard.....	13
ASME Sec. V Article 5 Straight Beam Calibration Blocks for Bolting...	13
ASME Sec. V Article 23 Ultrasonic Standards.....	13

Ultrasonic Reference Standards (Tube)

2-Notch Tube Standard.....	14
4-Notch Tube Standard.....	14
Unique Tube Standards for UT	14
13-Notch UT Standard	14

Ultrasonic Reference Standards (Bar)	
V-Notch and FBH Bar Standard.....	15
3-FBH Bar Standard	15
2-Piece Round Bar Standard.....	15
PWA (Pratt & Whitney Aircraft) SIS-315A; SIM-1 Standard	15
Ultrasonic Reference Standards (Other)	
Projectile Body UT Standards.....	16
API RP 2X Reference Standard	16
Miniature FBH Standard.....	16
Standards for In-Line Phased Array Calibration Systems	
Standards for In-Line Phased Array Calibration Systems	17
Deep Flat-Bottom Hole Drilling	
Deep Flat-Bottom Hole Drilling	17
Tech Scales	
Tech Scales (Pack of 5).....	17
Eddy Current Calibration Standards (Tube)	
ASME Sec. V Art. 8 Calibration Reference Standard– 2007 Code.....	18
ASME Sec. V Art. 8 Calibration Reference Standard– Pre-2007 Code..	18
I.D. FBH Calibration Standard	18
180° 3-Flaw Wearscale Standard	18
Circumferential Notch Eddy Current Standard.....	18
ASME Sec. V Article 26 ET Standards	19
Tube Support Simulation Ring	19
Specialized Tube Standards for ET.....	19
ID Thinning Standard	19
Eddy Current Calibration Standards (Other)	
3-Notch Surface Defect Calibration Standard	20
Bolthole Calibration Blocks.....	20
MIL-STD-271F Performance Verification Reference Block	20
Turbine Blade Reference Standards.....	20
Wheel Inspection Reference Standards	20
Air Force General Purpose Eddy Current Standard.....	21
Navy Eddy Current Reference Standard Kit.....	21
DC-10 Service Bulletin Reference Standards.....	21
Aircraft Manufacturer Standards	21
Magnetic Particle Standards	
GE Compressor Blade Standard	22
Ketos Ring	22
Flat Ketos Ring	22
ASTM E709 Magnetic Particle System Performance Verification Plate .	22
MIL-STD-271F Magnetic Particle Test Plate.....	23
Weight Lifting Gear Magnetic Particle Props	23

Liquid Penetrant Standards

NSTR-99 Liquid Penetrant Personnel Qualification Test Props.....	23
Liquid Penetrant Test Prop.....	23

Precision Dimensional Gages

Angle Gage.....	24
Corner Radius Gage.....	24
Fillet Radius Gage.....	24
Go No-Go Gage.....	24
Fillet Angle Gage.....	24

Services Available

Sinker EDM.....	25
Wire EDM.....	25
CNC Machining of Standards.....	25
CNC Milling.....	25
Turning and Boring.....	25
Surface Grinding.....	26
Replication and Recertification to NIST.....	26
Welding and Cladding.....	26
Surface Roughness Measurement.....	26
Electrical Conductivity Measurement.....	26

Sample Certification Report

Sample Certification Report for 4-Notch PWA Tube Standard.....	27
--	----

Quick Fax - Rapid Response Form

Quick Fax - Rapid Response Form (Use for RFQ, Info, Order, etc.).....	28
---	----

Price Lists

Current Standard Test Block Price List.....	29
Current Dimensional Inspection Price List.....	30

Get it right the FIRST time ... with our help!

In all cases, if you need assistance with the application, design, or the interpretation of specifications of your NDT reference standards, contact us. The benefits of past experience with similar requirements and the specialized knowledge available at PH Tool could eliminate the waste of trial-and-error engineering and lead to a quicker, more cost-effective solution. We serve our customers best by offering them personalized advice, guidance, customized solutions to their complex problems, and expert design and manufacture of standards.

WHAT IS EDM?

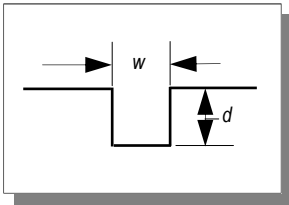
Electrical Discharge Machining (EDM) is a nonconventional metal removal machining method that employs the use of an electrode to machine the desired shape into a workpiece under carefully controlled conditions. EDM offers several advantages over conventional, "chip-making" machining methods including:

1. The ability to machine extremely narrow notches.
2. The ability to access hard-to-reach locations such as pipe/tube IDs without the need to section the workpiece.
3. The ability to hold very close dimensional tolerances.
4. The ability to machine harder materials and exotic alloys.
5. The ability to machine irregular shapes not otherwise possible.

All conductive materials are able to be EDM'd. EDM notches can be machined on both the OD and ID of pipe and tube. Notches can be machined on IDs as small as 0.040". Transverse (circumferential) notches are normally made with electrodes precisely ground to the respective radius of the workpiece. This ensures uniform notch depth along the notch length. Notches can also be made to match an irregular surface, or have a thumbnail (semi-elliptical) profile.

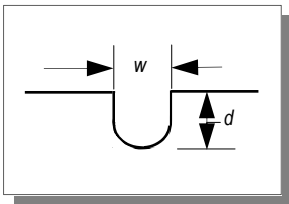
The basic notch shapes available are detailed below. All notch shapes below can be longitudinally or circumferentially oriented, and can be located on the OD or ID of hollow cylindrical products.

BASIC NOTCH SHAPES



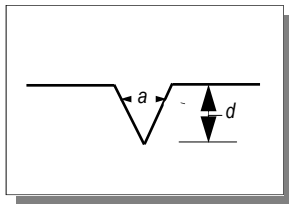
Square Notch

This notch is also referred to as a "Buttress" notch, and has parallel-sided walls and minimal corner radius at notch bottom. Typical of notches over 0.010" wide. Available in depths from 0.0001"; widths from 0.010"; and lengths from 0.005" through 3.00".



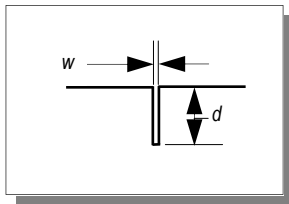
U-Notch

This notch has parallel-sided walls at the entry surface and a corner radius at notch bottom resembling a "U-shape". Typical of notches under 0.010" wide. Available in depths from 0.0001"; widths from 0.003"; and lengths from 0.005" through 3.00".



V-Notch

This notch has angled side walls that meet at the notch bottom. Typical V-notch included angles (a) are 40°, 45°, 60°, 70°, 75° and 90°, with 60° being the most common. V-notch half-angle should complement beam angle for maximum response. Available in depths from 0.002", and lengths from 0.020" through 2.00".

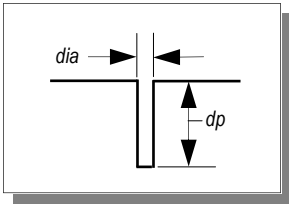


Nano Notch

The absolute narrowest notch available today. Available in widths from 0.0006", depths from 0.0001"; lengths from 0.005" through 1.00". Some depth limitations exist on ultra-narrow notches depending on configuration and alloy. Call Technical Sales to discuss possibilities.

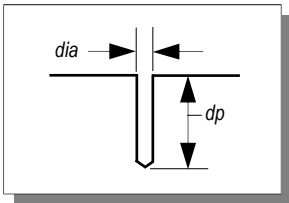
HOLES, FLAT-BOTTOM AND OTHER

PH Tool offers many different types of holes used in NDT today. The popular ones are listed below. If you don't find what you're looking for, call us and we'll be happy to discuss how it can be done. We employ both conventional machining (drilling) and nonconventional (EDM) in the hole-making process. The determining factors we consider in choosing a method are machinability of the workpiece, accessibility, hole diameter and depth.



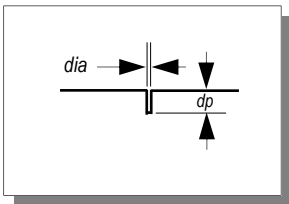
Flat-bottom hole

The flat-bottom hole (FBH) is machined to have a flat reflecting surface at the hole bottom. The hole bottom is typically parallel to the beam entry surface, but can be machined at other desired angles. Primarily used in Ultrasonic testing, with some application in Eddy Current testing, FBHs can be machined just about anywhere they are needed for a particular inspection. Available in diameters from .010". ID FBHs can be machined without the need to section the part by our EDM process.



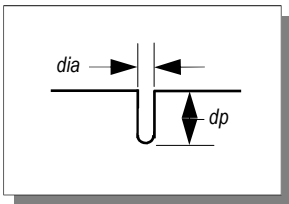
Side-drilled hole

The side-drilled hole (SDH) is typically a drilled hole, the side wall of which is used as the reflecting surface. Unlike a FBH, the bottom of a SDH serves no purpose. SDHs are often reamed after initial drilling. SDHs are often drilled in pipe walls at specified locations from the diameter, e.g.: 1/4T, 1/2T, and 3/4T. They can be drilled either longitudinally or circumferentially to the axis of the pipe. They can also be machined in plate, bar or other products. Primary use is Ultrasonic testing. Available in diameters from .010".



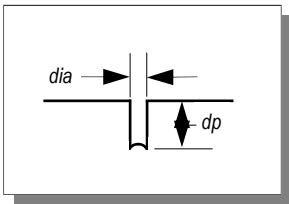
Micro-sized hole

The micro-sized hole (MSH) is a small diameter hole used primarily in Liquid Penetrant inspection. Hole diameter is normally 0.004 to 0.005", and hole depth is 0.008 to 0.010". These micro-sized holes meet the requirements of the U.S. Navy's NSTR-99 Rev. 2 (Qualification Examination Requirements for Nondestructive Test Personnel). They can be machined in welded plate, pipe, bolts, or any test prop. Also available in diameters and depths other than stated above. Diameters as small as 0.0015" (0.038mm) are possible, depending on depth.



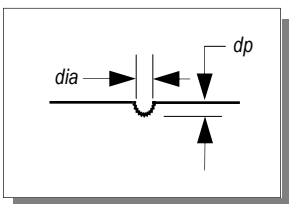
Concave Radius-bottom hole

The concave radius-bottom hole is machined with a concave radius at the hole bottom. Applications include ID pitting of tube or pipe for Eddy Current Inspection; and Liquid Penetrant test props. Referred to as a "Round-bottom hole" on the ASME J-10 block. Available in diameters from 0.003".



Convex Radius-bottom hole

The convex radius-bottom hole is machined with a convex radius at the hole bottom. Available in diameters from 0.030".

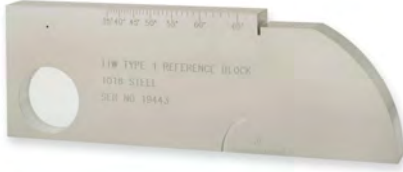


Irregularly-shaped pits

These holes and pits are machined in irregular configurations, not described above. Includes oval-bottom pits, round-bottom pits, 90° conical pits, star-shaped, square holes, hex holes, and realistic pits. EDM pit electrodes can be cast from real pits and used to reproduce actual pits very accurately. If you still haven't seen the hole you need, use your imagination...we'll figure out how to accomplish it.

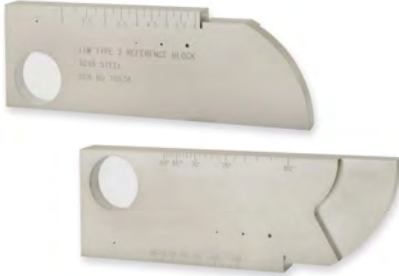
ULTRASONIC TEST BLOCKS

IIW-Type 1 Block



Used for calibration of shear and longitudinal transducers, and verification of shear wedge exit point and refracted angle. Can also be used for resolution and sensitivity checking. Includes a 4.0" radius on one end and a 1.0" radius by .060" deep. Also includes a .060" diameter and a 2.0" diameter hole.

In accordance with International Institute of Welding and ASTM E164 specifications. Dimensions: 12.0" x 4.0" x 1.0". Metric version available.



IIW-Type 2 Block

This is a modified version of the original IIW-Type 1 design. Includes a 2.0" radius x .250" deep cut-out superposed on the 4.0" radius for distance calibration. Also includes numbers 3, 5 and 8 through holes (3/64", 5/64" and 8/64" diameter) and distance calibration marks to the 2.0" hole. In accordance with International Institute of Welding, ASTM E164, and U.S. Air Force NDI Manual T.O. 33B-1-1 specifications. Dimensions: 12.0" x 4.0" x 1.0". NSN is 6635-00-415-9225. Metric version available.



DC Block

AWS-type block used for shear wave distance calibration. Contains a 1.0" radius overlaying a 2.0" radius on a 180° segment. In accordance with ASTM E164 and BRR/AWS X-1 specifications.

Dimensions: 2.0" radius section is .5" thick, 1.0" radius section is 1.0" thick. Metric version available.



SC Block

AWS-type block used for shear wave sensitivity calibration. Contains two .062" diameter through holes. In accordance with ASTM E164 and BRR/AWS requirements. Dimensions: 3.00" x 1.25" x .905". Metric version available.



DSC Block

AWS-type block used for shear wave distance and sensitivity calibration. Contains a 1.0" radius opposite a 3.0" radius. The 3.0" radius includes a .375" deep x .032" wide radiused slot. Also contains a 0° reference point for checking exit point on wedge, and a .125" diameter through hole and corresponding markings at 45°, 60° and 70° for measuring actual refracted angle. In accordance with ASTM E164 and AWS 6.16.1B.

Dimensions: 1.0" thick. Metric version available.



DS Block

AWS-type block used for longitudinal distance and sensitivity calibration. Contains a 2.0" high section between two 4.0" sections. In accordance with AWS requirements. Dimensions: 6.0" x 4.0" x 2.0".

PH TOOL
REFERENCE STANDARDS

www.phtool.com
email: sales@phtool.com

3

ULTRASONIC TEST BLOCKS



4-Step Block

Thickness and linearity calibration. This 4-Step block comes in thicknesses of .250", .500", .750", and 1.000". Step face measures .750" x .750". In accordance with ASTM E797. Two metric versions available. (4A and 4B) NOTE: Variations of this block and the 5-Step block below are available if additional steps are preferred. Also, larger step faces are offered for use with large diameter transducers.



5-Step Block

Thickness and linearity calibration. This 5-Step block comes in thicknesses of .100", .200", .300", .400" and .500". Step face measures .750" x .750". In accordance with ASTM E797. Two metric versions available. (5A and 5B)



Type MAB Miniature Angle-Beam Calibration Block

Also known as a "Rompas" block, this ASTM and U.S. Air Force miniature angle beam block is a substitute for the DSC block for distance, beam index, refracted angle and sensitivity calibration. Contains a 1.0" radius opposite a 2.0" radius, and a 5/64" diameter x .750" deep flat-bottom hole. In accordance with ASTM E164 and U.S. Bureau of Public Roads, Type B specifications. Dimensions: 1.0" thick. Metric version available.



IOW Beam Profile Block

Used for beam profile measurement of angle beam transducers and measurement of transducer angles. Contains nine 1.5mm diameter x 22mm deep side drilled holes. In accordance with British Standard 2704 requirements. Dimensions: 305mm x 75mm x 50mm (approx. 12" x 3" x 2").



AWS Resolution Block (RC Block)

Used for checking resolution capabilities of angle beam transducers. Contains three sets of .062" diameter through holes for 45°, 60° and 70°. In accordance with AWS Welding Highway and Railway Bridges specification D1.1 and D2.0. Dimensions: 6.0" x 3.0" x 1.0"



NAVSHIPS Test Block

Used for distance amplitude correction, sensitivity levels and flaw depth information. Contains six 3/64" diameter side-drilled through holes at distances of .25" to 2.75" in .25" increments. In accordance with MIL-STD-271G Figure 9, and NAVSHIPS specification 0900-006-3010/ Section 6. Also known as a "Mare Island block." Dimensions: 12.0" x 3.0" x 1.25". Metric version also available. A Navy "3020" version, containing an additional near-surface (0.125") hole and 125-250 Ra scanning surfaces, is also available.

ULTRASONIC TEST BLOCKS



Miniature Resolution Block

Used for checking resolution capabilities and calibrating high resolution test equipment. Contains four .188" wide x .625" long milled slots to simulate flat plate reflectors at metal travel distances of .015", .020", .025" and .030". Also contains six flat-bottom holes, three each with diameters of 1/64" and 3/64" at metal travel distances of .020", .025" and .030". Dimensions: 3.625" x 1.0" x .125".



30 FBH Resolution Block

Used for determining resolution and sensitivity capabilities and for producing area amplitude and distance amplitude plots for normal beam transducers. Contains ten flat-bottom holes at 3/64" diameter, ten at 5/64", and ten at 8/64". Metal travel distances range from .050" to 1.250". In accordance with ASTM E127 and E428. Dimensions: 11.0" x 4.0" x 1.5". Metric version also available.



ASME N-625 Reference Plate

Used for longitudinal, shear, and surface wave sensitivity calibrations. Contains six flat-bottom holes: three 4/64" diameter, one each at depths of .050", .250", and .500"; one 4/64" diameter at 1.500" deep; one 8/64" diameter at 1.625" deep; and one 16/64" diameter at 1.750" deep. In accordance with ASME 1275N Boiler and Pressure Vessel Code, Section III, Nuclear Vessels.



Miniature IIW-Type 2 Block

This small and lightweight version of the full-sized IIW-2 does everything its big brother does, at a fraction of the size and weight. The PH Tool Mini IIW-2 measures 1" thick x 2" tall x 6" long, and contains both 1" and 2" radii. An .080" wide sensitivity slot and two sensitivity holes, one at 1/16" diameter, and one at 1/8", are located .500" from each scanning surface. A large 1" diameter through-hole is included, along with a convenient step measuring .500" thick in one corner. Angle beam exit markers from 35° to 75° are machine-engraved on one face. Dimensions are 1.000" x 2.000" x 6.000". In accordance with PH Drawing. No. 10147.



V1/5 (A2) Calibration Block

For calibrating ultrasonic flaw detection equipment in both laboratory and on-site conditions. Our version of this block includes a 100mm radius, 1.5mm and 50.0mm holes, engraved reference mark scales, and two optional slots at the zero point which provide calibrating signals at intervals of 100mm range. In accordance with British Standard BS 2704 Block A2 Mod. 1, Fig.2, German Standard DIN 54-120, EN 12223, Fig. 2, and ISO 2400. This block is not to be confused with the new EN 12223 / ISO 2400 Calibration Block No. 1 (also called the K1 block) which is similar but contains a 3.0mm through-hole rather than a 1.5mm hole. See our test block store for this block. Dimensions are 300mm x 100mm x 25mm.



V2 (A4) Calibration Block

Small calibration block for on-site checking of miniature shear wave probe index, time base, beam angle and gain. Includes a 25mm and 50mm radius, 1.5mm hole (or 5mm), engraved reference mark scales from 35 to 75 degrees. In accordance with British Standard BS 2704 block A4, Fig. 4, and ISO 7963 Cal block No. 2, Fig. 1. Dimensions: 75mm x 43mm x 25mm (12.5 and 20mm thick blocks are also available.)

PH TOOL
REFERENCE STANDARDS

www.phtool.com
email: sales@phtool.com

ULTRASONIC TEST BLOCKS



90° Curved 5-Step Block

Special curved step block for thickness and linearity calibration of curved surfaces. This 90° Curved 5-Step block is machined from solid 2" diameter bar with step thicknesses of .100", .200", .300", .400" and .500". ID radius is 0.50". In accordance with PH Tool Drawing No. 10177. Step face is 1.000" x 90° arc.



VW Step Block

Metric 8-step thickness and linearity calibration block. This block comes in thicknesses of 1.0, 2.0, 3.0, 4.0, 5.0, 6.0, 7.0, and 8.0mm. Step face measures 15mm x 15mm.



Thin Step Block

Special 4-step block for thickness and linearity calibration of thin materials. This block comes in thicknesses of 0.040", 0.060", 0.080", and 0.100". Step face measures 0.750" x 0.750". Manufactured in accordance with PH Tool drawing no. 10073. Metric version with steps measuring 1.0, 1.5, 2.0, and 2.5mm and face size of 20mm x 20mm is also available.



Magna-Thin Step Block

Special 5-step block for thickness and linearity calibration of thin materials. This block comes in thicknesses of 0.020", 0.040", 0.060", 0.080", and 0.100". Step face measures 0.750" x 0.750". Manufactured in accordance with PH Tool drawing no. 10183. Metric version with steps measuring 0.5, 1.0, 1.5, 2.0, and 2.5mm and face size of 20mm x 20mm is also available.



10-Step Block

Special step block for thickness and linearity calibration. There are three versions of the block available. The 10-Step Inch version is made to PH Tool drawing no. 10142 and goes from 0.100" to 1.000" in 0.100" increments. Face measures 0.750" x 0.750". The 10-Step Metric 10A version (drawing no. 10143) goes from 2.5 to 25.0mm in 2.5mm increments. The 10-Step Metric 10B version (drawing no. 10144) goes from 2.0 to 20.0mm in 2.0mm increments. Step face on both metric versions is 20mm x 20mm.



Tipsy Step Block

Special Step Block for thickness and linearity calibration. This versatile block contains eight (8) steps. Set it down on one side and get the 1.0, 2.0, 3.0 and 4.0" steps. Then "Tip" it over and get the 1.5, 2.5, 3.5, and 4.5" steps. Step faces measure 1.00" x 1.00". Manufactured in accordance with PH Tool drawing no. 10068. Step thickness tolerance is ± 0.002 ". Metric version with steps measuring 25.0, 37.5, 50.0, 62.5, 75.0, 87.5, 100.0, and 112.5mm also available. Step faces on metric block measure 25.0mm x 25.0mm. Our new **Universal Tipsy Block** design combines both measurement scales on one handy block. Stand it up to calibrate on the 1.0, 2.0, 3.0, and 4.0" thicknesses; then "Tip" it over to get the 25.0, 50.0, 75.0, and 100.0 mm steps.

ULTRASONIC TEST BLOCKS

Sizing Blocks



EDM Slot Sizing Block No. 10072 - This block contains nine EDM slots from 0.100" to .900" deep. Slot width is 0.011". Nominal depth is laser engraved on the side of the block. In accordance with PH Dwg No. 10072. Alloys: 1018 steel-nickel plated, Type 304 stainless steel, 7075-T6 aluminum-anodized, and others by request. Block dimensions are 1.000" x 1.000" x 10.000". Alternative version of this block with nine 1/16" diameter through holes is called Drilled Hole Sizing Block No. 10074. In accordance with PH Dwg. No. 10074.



"FAST" UT Sizing Block - This popular block contains 1/32" dia. SDHs at 0.100", 0.200", 0.300", 0.400" with corresponding beam exit marks for 70° engraved on both sides. Also contains two EDM notches at 0.050" and 0.100" deep x .011" wide x 0.500" long. Alloy: ASTM A516 Grade 70 PVQ plate. In accordance with PH Dwg. No. 10539 Rev. 01. Dimensions: 0.500" x 1.000" x 12.000".

Specials with EDM slots and holes are also available.

PHASED ARRAY TEST BLOCKS

PACS™ Block



New Phased Array calibration block used for angle beam verification, probe angle exit point, calibration for wedge delay, sensitivity, DAC/TCG for thicknesses up to 2", and crack sizing. The three radii (0.500", 1.000", and 2.000") allow for velocity and sound path calculations. Block contains five holes at 3/64" diameter drilled through the 1.000" width, located at .100, .200, .400, .600, .800, 1.200, 1.400, 1.600, 1.800, and 1.900" from the respective scanning surface. Generous hole spacing eliminates "ghost" images from adjacent holes. Also includes an engraved scale from 30° to 70° associated with the .800" hole. Dimensions: 18.0" x 2.0" x 1.0". In accordance with PH Tool Drawing No. 10173. Designed jointly by PH Tool LLC and Davis NDE.

Mini PACS™ Block



Mini PACS™ Block is a smaller, portable version of the original PACS™ Block. The block includes a total of four holes at 3/64" diameter drilled through the 1.000" width, located at .200, .400, .600, .700, .800, .900, 1.100, and 1.300" from the respective scanning surface. Dimensions: 1.500" tall x 1.000" wide x 10.00" long. In accordance with PH Tool Drawing No. 10192. Designed jointly by PH Tool LLC and Davis NDE.

PACS™ Notch Block



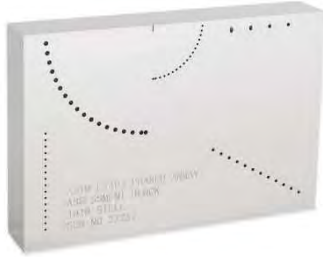
The PACS™ Notch Block has been specially designed for use with Phased Array instruments used for sizing of OD and ID-connected cracks. The block contains four EDM slots at depths of 20, 40, 60, and 80% and a width of .031". Standard thickness is 1.000"; however, other sizes can be ordered. Dimensions: 1.000" thick x 2.000" wide x 7.00" long. In accordance with PH Tool Drawing No. 10210. Designed jointly by PH Tool LLC and Davis NDE.

PH TOOL
REFERENCE STANDARDS

www.phtool.com
email: sales@phtool.com

PHASED ARRAY TEST BLOCKS

ASTM E2491 PA Assessment Block



The PH Tool ASTM E2491 Phased Array Assessment Block is a general purpose Phased Array calibration block used for beam characterization and evaluation of system performance characteristics. Use it as baseline block to determine long-term instrument performance changes, generate DAC curves, and evaluate linear/angular resolution, focusing ability and beam steering capability. With a variety of targets, this small, lightweight block is also perfect for customer demonstrations of phased array ultrasonics capabilities. This block is also referred to as a "Type B" block. Dimensions: 150mm x 100mm x 25mm. In accordance with ASTM E2491 and PH Tool Drawing No. 10208.

Phased Array Type A Block (IIW-Type)



The Phased Array "Type A" Calibration Block is used during the initial setup and calibration of a phased array ultrasonic unit. This block can be used to perform tasks such as beam angle verification, calibration for wedge delay, sensitivity calibration, performing DAC/TCG, and more. This block has similar dimensions to an IIW-Type Block, but has been specially-engineered for phased array applications. Blocks include both 50.0mm and 25.0mm radii, (19) through holes at 1.0mm diameter, (1) through hole at 2.0mm diameter, (4) FBHs at 2.0mm diameter x 2.0, 4.0, 6.0, and 8.0mm deep, (4) FBHs at 4.0mm diameter x 1.0, 3.0, 5.0, and 7.0mm deep, (3) FBHs at 2.0mm diameter x 3.0mm deep machined into the 25mm radius, and (4) EDM notches at 0.1, 0.2, 0.3, and 0.4mm deep x 0.5mm wide x 25.0mm long. Block dimensions are 25.0mm thick x 100.0mm tall x 300.0mm long. In accordance with PH Tool Drawing No. 10217.

Phased Array Calibration Block No. 2



This new Phased Array calibration block design by PH Tool contains all of the required features on the ASME Section V, Article 4 Basic Calibration Block yet spaces the holes out on a longer, narrower block. The block contains three holes at 3/32" diameter drilled through the 1.500" width, located at 1/4T, 1/2T, and 3/4T. It also contains two EDM notches at 2% deep x .010" wide x 1.500" long on opposite surfaces of one end. Dimensions: 14.0" x 1.5" x .75" thick. In accordance with PH Tool Drawing No. 10178.

Phased Array NAVSHIPS Block



This special Phased Array version of the popular NAVSHIPS block solves the problem of too many holes interfering with one another. The block contains four holes at 3/64" diameter drilled through the 1.250" width. The holes are located at .250, .750, 1.250, 1.750, 2.250, and 2.750". Dimensions: 12.0" x 3.0" x 1.25". In accordance with PH Tool Drawing No. 10168.

PH TOOL
REFERENCE STANDARDS

www.phtool.com
email: sales@phtool.com

ULTRASONIC TEST BLOCKS

ASTM Area Amplitude Set of 8



Set of eight blocks used to determine the relationship between flaw size and echo amplitude by comparing signal responses. Metal travel distance is 3.000" for all blocks. In accordance with ASTM E127 and E428. Flat-bottom hole diameters for this set per E127 Table 3 are: 1/64", 2/64", 3/64", 4/64", 5/64", 6/64", 7/64" and 8/64". Includes ultrasonic response plot. ASTM blocks in aluminum and steel are not recommended for long-term immersion. If blocks are intended for this purpose, please contact Technical Sales to discuss industrial coating options.

ASTM Distance/Area Amplitude Set of 10

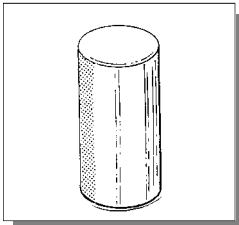


Basic set of ten blocks used to determine dead zone, sensitivity, distance and area amplitude linearity measurements. In accordance with ASTM E127 and E428. Flat-bottom hole diameters and metal travel distances for this set per E127 Table 1 are: 3/64" at 3.000" MTD; 5/64" at .125", .250", .500", .750", 1.500", 3.000" and 6.000" MTD; and 8/64" at 3.000" and 6.000" MTD. Includes ultrasonic response plot. ASTM blocks in aluminum and steel are not recommended for long-term immersion. If blocks are intended for this purpose, please contact Technical Sales to discuss industrial coating options.

ASTM Distance Amplitude Set of 19

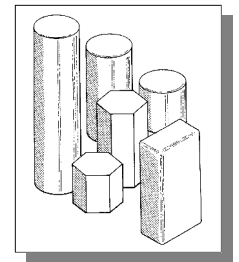


Set of nineteen blocks used to determine the relationship between metal distance and signal amplitude. All blocks have the same size flat-bottom hole. Hole diameter must be specified when ordering. (3/64", 5/64" or 8/64") In accordance with ASTM E127 and E428. Metal travel distances for this set per E127 Table 4 are: .063", .125", .250", .375", .500", .625", .750", .875", 1.000", 1.250", 1.750", 2.250", 2.750", 3.250", 3.750", 4.250", 4.750", 5.250" and 5.750". Includes ultrasonic response plot. ASTM blocks in aluminum and steel are not recommended for long-term immersion. If blocks are intended for this purpose, please contact Technical Sales to discuss industrial coating options.



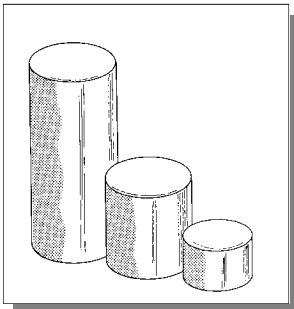
ASTM Single Blocks

Used for measurement of the sensitivity and/or resolution of normal beam transducers. Available with flat-bottom holes with diameters from 1/64" to 8/64", with MTD from .063" to 12.000". Per ASTM E127 and E428. ASTM blocks in aluminum and steel are not recommended for long-term immersion. If blocks are intended for this purpose, please contact Technical Sales to discuss industrial coating options.



ASTM Specials

Special blocks are available in exotic alloys, shapes other than the standard 2" diameter, metric dimensions, concave or convex radius ends, or non-typical quantities of blocks per set. Extra-long blocks up to 40" metal travel distance at 4 inch diameter are available. In accordance with ASTM E127 and E428 specifications. Custom hardwood storage cases available.



Westinghouse Reference Standards

The Westinghouse Reference Standard Set 84350KA is made of AISI 4340 steel, which has been found to be acoustically similar to rotor and disc material. The set consists of one B-1, one B-3 and one B-11 block. In accordance with Westinghouse Process Spec - Ultrasonic Examination No. 84350KA Appendix I, and ASTM E428 requirements. Flat-bottom hole diameter is .0625" for all blocks. Metal travel distance is 1.000", 3.000" and 11.000". Block diameter is 2" for B-1 block and 3" for B-3 and B-11 blocks.

PH TOOL
REFERENCE STANDARDS

www.phtool.com
email: sales@phtool.com

ULTRASONIC TEST BLOCKS

ASTM E317 Horizontal and Vertical Linearity Block, Fig. 1



Used for evaluating the horizontal and vertical linearity characteristics of ultrasonic pulse-echo testing systems. Figure 1 block is constructed from 7075-T6 Aluminum and contains two 3/64" diameter side-drilled holes. In accordance with ASTM E317 Figure 1. Dimensions: 3.00" x 2.00" x 1.00".

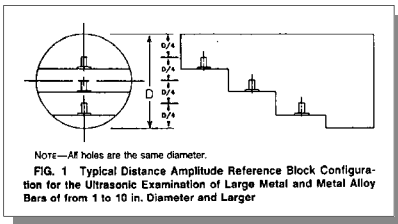
ASTM E317 Resolution Block, Fig. 6



Used for evaluating the resolution characteristics of ultrasonic pulse-echo testing systems. Figure 6 block is constructed from 7075-T6 Aluminum and contains six 3/64" diameter flat-bottom holes. In accordance with ASTM E317 Figure 6. Dimensions: 2.00" x 1.00/3.30" x 8.00". Other alloys and hole diameters available. Metric version also available.

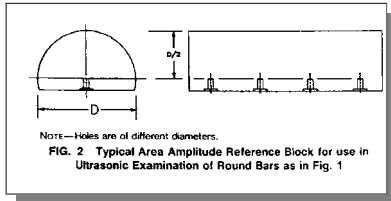
ASTM E1158 Distance Amplitude Blocks

This specification governs the material selection and fabrication of reference blocks for the pulsed longitudinal wave contact or immersion ultrasonic examination of metal and metal alloy production round bar stock between 1" and 10" in diameter. It is recommended that the blocks be fabricated from material representative of the production material to be examined. The Figure 1 block contains a number of holes of the same diameter at various distances from the scan surface. Typical hole diameter is 5/64" or larger. Figure 3 block for square or rectangular bar over 1" is also available.



ASTM E1158 Area Amplitude Blocks

This specification governs the material selection and fabrication of reference blocks for the pulsed longitudinal wave contact or immersion ultrasonic examination of metal and metal alloy production round bar stock between 1" and 10" in diameter. It is recommended that the blocks be fabricated from material representative of the production material to be examined. The Figure 2 block contains holes of different diameters at the same distance from the scan surface. Typical hole diameters range from 2/64" and 8/64" or larger. Figure 4 block for square or rectangular bar over 1" is also available.



MIL-STD-2154 Ultrasonic Test Blocks

MIL-STD-2154 UT Test Blocks

The following UT Test Blocks from MIL-STD-2154 are available:

- **Figure 3** - Convex Surface Reference Standard Configuration for Longitudinal Wave Inspection.
- **Figure 4** - Standard Ultrasonic Test Block for Angle Beam Examination.
- **Figure 5** - Hollow Cylindrical Standards.

ULTRASONIC CALIBRATION BLOCKS/STANDARDS



ASME Sec. V Basic Calibration Blocks

Used for establishment of primary reference responses for UT examination of welds. Block contains three DAC side-drilled holes at 1.5" deep minimum at diameters between 3/32" and 1/4" depending on the block thickness (T). Hole locations through the thickness are 1/4, 1/2 and 3/4T. Also contains two notches measuring 2%(T) deep x 1.0" long minimum. Spec: ASME Section V, Article 4, Figure T-434.2.1. Dimensions: T x 6.25" x 3(T) min. Available in thicknesses of 1/2", 3/4", 1 1/2", 3", and 5". Older version to ASME Section V, Article 5, Figure T-542.2.1 (.040" deep min / 2.0" long minimum) is also available upon special request.



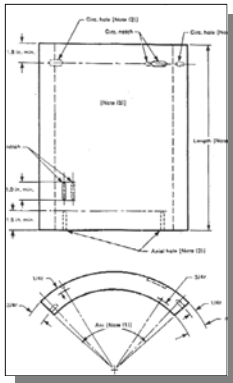
ASME Sec. V Basic Calibration Blocks Long Version

Special long version for 60/70° transducers or phased array. The additional length allows for a full skip to the "top" notch. Used for establishment of primary reference responses for UT examination of welds. Block contains three DAC side-drilled holes at 1.5" deep minimum at diameters of between 3/32" and 3/16" depending on the block thickness (T). Hole locations through the thickness are 1/4, 1/2 and 3/4T. Also contains two notches measuring 2%(T) deep x 1.0" long minimum. Spec: ASME Sec V, Art 4, Fig T-434.2.1. Dimensions: T x 6.25" x 8(T). Available in thicknesses of 1/2", 3/4", 1 1/2", & 3".



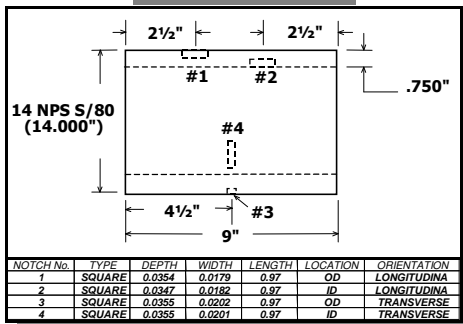
ASME Sec. V Angle Beam Cal Blocks

The basic calibration block for weldments shall be a section of pipe of the same nominal size, schedule, heat treatment, and material specification as the material being examined. Contains four (4) notches (longitudinal and circumferential on both OD and ID) at a depth of 9 1/2% of nominal wall by 1" long min. Standards can be machined from either PH Tool or customer-supplied material. Spec: ASME Sec. V, Article 4, Figure T-434.3 (Calibration Block for Pipe).



ASME Sec. XI Basic Piping Cal Block

Complete manufacture of the ASME Section XI Blocks including: supplying of pipe, machining of OD/ID (if needed), cladding (if needed), machining of all notches and side-drilled holes (SDH), machine engraving of all essential info including alloy, specification, diameter, wall thickness and serial number. Blocks normally contain: one axial OD notch, one axial ID notch, one circ OD notch, one circ ID notch, two axial SDHs at 1/4 and 3/4T, and two circ SDHs at 1/4 and 3/4T. Can also be made from customer-supplied material. In accordance with ASME Sec. XI, Div. 1, Fig. III-3230-2. PH Tool is NUPIC approved.



ASME Sec. III NB-2552.3 Standards

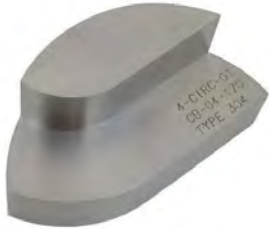
Used for ultrasonic examination of pipe and tubing in both circumferential and axial directions. The reference specimen shall be of the same nominal diameter, wall thickness, nominal composition and heat treated condition as the product being examined. Contains four (4) notches of square, U or V shape at a depth not greater than the larger of 0.004" or 5% of nominal wall by 1" long max. Defects are located so that indications are separate and distinct. In accordance with ASME Section III, Division 1, NB-2552.3. Sample sketch at left shows a 14" NPS Schedule 80 pipe section with notch As-builts in grid below.



www.phtool.com
email: sales@phtool.com

ULTRASONIC CALIBRATION BLOCKS/STANDARDS

PDI Contoured Calibration Blocks for Dissimilar Metal (DM) Welds



Contoured calibration blocks are used in the manual examination of dissimilar metal (DM) welds and base materials including piping susceptible to Stress Corrosion Cracking (SCC). The blocks are used to establish a reference sensitivity level from which subsequent exams may be compared. The blocks are precisely machined to fit contoured search units for axial and circumferential scanning directions. Customer specifies block contour radius based on diameter of material being inspected. Blocks are manufactured in Type 304 or Type 316 Stainless Steel, and are certified to meet Performance Demonstration Initiative PDI-UT-10 and PDI-UT-8.



RECERTIFICATION OF TEST BLOCKS



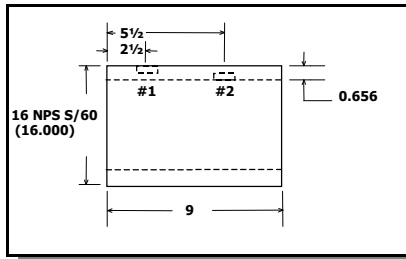
In addition to the inspection of newly-made standards and test blocks, PH Tool also offers recalibration/recertification services. This service is offered on products manufactured by us, as well as by other manufacturers. Typical items that we recertify are: ultrasonic test blocks such as IIW and step blocks, and ASTM flat bottom hole reference block sets made to ASTM E127 and E428. Blocks of unknown origin or with missing documentation may be able to be recertified, saving the expense of replacement.

If the specific alloy or grade of an existing specimen is in question, PH Tool also offers **Positive Material Identification (PMI)** services. These tests are capable of positively determining the exact chemistry of the item in question in a non-invasive manner.

How often should I have my Ultrasonic Test Blocks recertified?

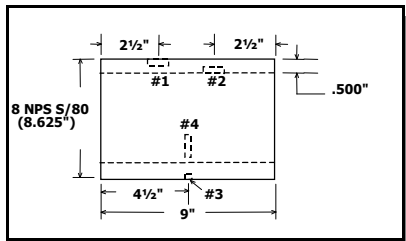
This question is becoming more and more common. Ten years ago, customers rarely sent UT blocks back to the manufacturer for recertification. Now, many do. It may be that the auditing or certifying agencies are beginning to look at test blocks as Measuring & Test Equipment (M&TE) and require that they be verified as time passes. We have seen situations where blocks that have been used extensively begin to exhibit dimensional changes. We have even observed blocks that are worn to the point that they no longer meet the intended specifications. Conversely, some blocks still look absolutely new after 10 years. Clearly, block condition, and the need to recertify, is influenced by the amount of use/abuse to which the block has been subjected.

ULTRASONIC REFERENCE STANDARDS



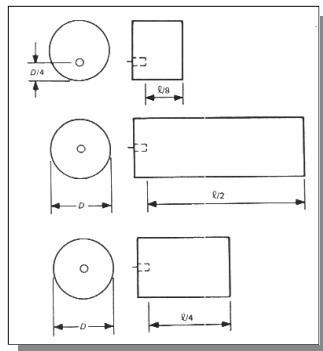
2-Notch Pipe Standard

Typical standard for circumferential scanning containing two (2) notches, one (1) OD longitudinal and one (1) ID longitudinal. The material shall be of the same diameter, wall thickness, material spec, and heat treatment as the material being inspected. Can be customer-supplied or PH Tool-supplied. Typical length required is 9 to 12" for contact testing, and 36 to 48" for immersion testing. Notch location can be customer-specified. Standards can be made 360° (full diameter), however, arc lengths of 90° to 180° are common for larger diameters. This design is typical of many UT specifications including: ASTM E-213, ASME Sections III and V, GE P3C-AL-0300, MIL-T-16420K, ASME SA-655, MIL-STD-271F, MIL-STD-2132, among others.



4-Notch Pipe Standard

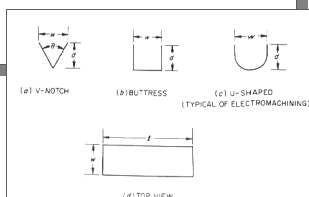
Typical standard for circumferential and longitudinal scanning containing four (4) notches, one (1) OD longitudinal, one (1) ID longitudinal, one (1) OD circumferential, and one (1) ID circumferential. The material shall be of the same diameter, wall thickness, material spec, and heat treatment as the material being inspected. Can be customer-supplied or PH Tool-supplied. Typical length required is 9 to 12" for contact testing, and 36 to 48" for immersion testing. Notch location can be customer-specified. Standards can be made 360° (full diameter), however, arc lengths of 90° to 180° are common for larger diameters. This design is typical of many UT specifications including: ASTM E-213, ASME Sections III, V and XI, MIL-T-16420K, ASME SA-655, MIL-STD-271F, among others.



ASME Sec. V Art. 5 Straight Beam Calibration Blocks for Bolting

These calibration blocks are manufactured in accordance with Figure T-534.3 and contain FBHs drilled in the axial direction of the block. Block material and examination surface finish shall be the same or equivalent to the bolting under examination. Block designations A, B, and C are available. Contains one (1) FBH from 1/16" to 3/8" diameter depending on examination material diameter. In accordance with ASME Section V, Article 5, Figure T-534.3, Straight Beam Calibration Blocks for Bolting.

ASME Section V Article 23 Ultrasonic Standards



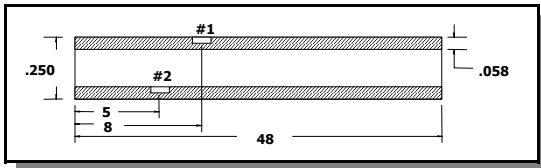
ASME Sec. V Art. 23 Ultrasonic Standards

All calibration and reference standards identified in Article 23 are available. Specifications include SA-388, SA-435/SA-435M, SA-577/SA-577M, SA-578/SA-578M, SA-609, SA-745, SB-509, SB-510, SB-513, SB-548, SE-113, SE-114, SE-213, SE-214, and SE-273.

ULTRASONIC REFERENCE STANDARDS (TUBE)

2-Notch Tube Standard

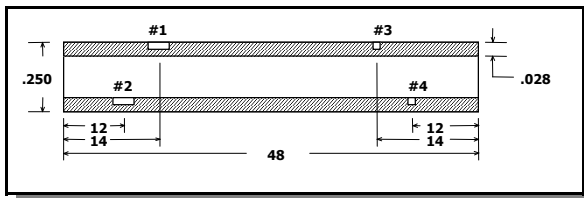
Typical standard for circumferential scanning containing two (2) notches, one (1) OD longitudinal and one (1) ID longitudinal. Typical length required is 48".



Notch depth, width, and length vary by specification. Notch location can be customer-specified. ID notch location can be 12" from end on IDs over approximately 0.180". Reduces to 6" from end on 0.080" ID. This design is common to many UT specifications including MIL-T-16420K and MIL-T-23226.

4-Notch Tube Standard

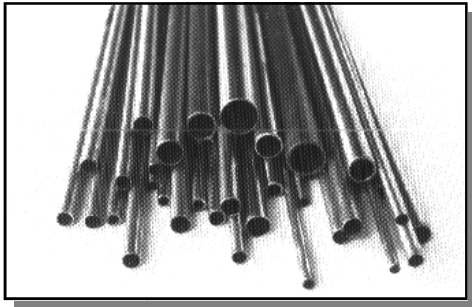
Typical standard for circumferential and longitudinal scanning containing four (4) notches, one (1) OD longitudinal, one (1) ID longitudinal, one (1) OD circumferential, and one (1) ID circumferential. Typical length required is 48".



Notch depth, width, and length vary by specification. Notch location can be customer-specified.

ID notch location can be 12" from end on IDs over approximately 0.180". Reduces to 6" from end on 0.080" ID.

This design is common to many UT specifications including Pratt & Whitney's PWA SIM 4E SIS 26B.

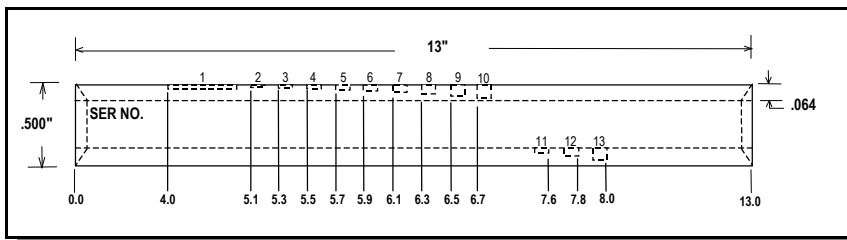


Unique Tube Standards for UT

Custom variations are also available containing EDM notches, FBHs (OD and ID), wall thinning, simulated ID pitting, and other unusual discontinuities. Also includes standards of extra-long overall length, very small IDs, and exotic alloys such as tantalum and iridium. Send us your sketch of any unique standard and we'll provide a prompt price quotation.

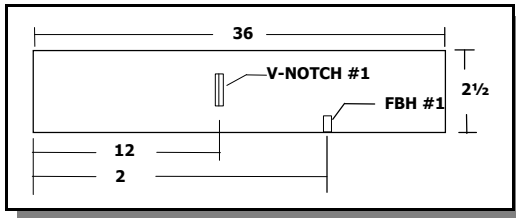
13-Notch UT Standard

Custom standard containing 13 EDM notches. Twelve (12) are .100" long and are separated by .100". One (1) is 1.000" long. Notch depth varies from 10% to 90% of wall thickness. Notch width is 0.005".



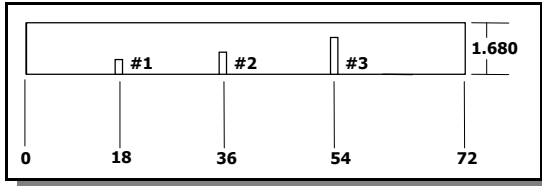
Narrower notch widths are available if preferred or if standard will be dual purpose UT/ET., All notches on this standard are longitudinally oriented, however circumferential notches can be machined also.

ULTRASONIC REFERENCE STANDARDS (BAR)



V-Notch and FBH Bar Standard

Popular standard for round bar inspection containing one (1) circumferentially oriented V-Notch (normally 60° included angle), and one (1) FBH. Notch depth and length, and FBH depth and diameter vary by specification. V-Notches are uniformly deep relative to the diameter. V-Notch angles other than 60° are available.

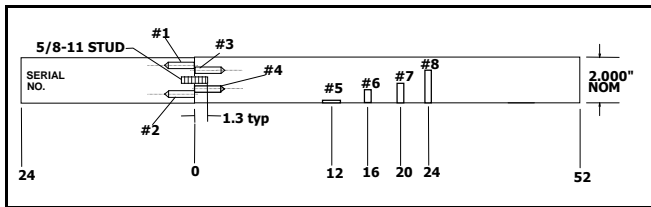


3-FBH Bar Standard

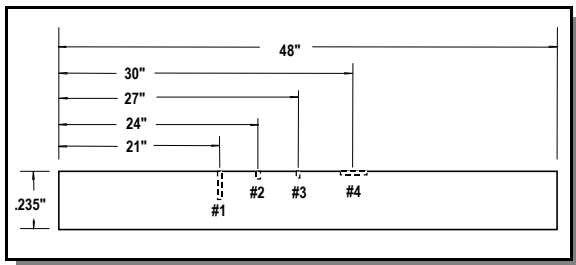
Popular standard for round bar inspection containing three (3) FBHs of the same diameter at different depths. FBH depths on this standard are 1/4D (25% of diameter), 1/2D, and 3/4D. FBH diameters are normally from 1/64" through 5/64", with 3/64" being most common. More complex standards containing additional holes and/or notches are available. See below for details.

2-Piece Round Bar Standard

Standard consists of two sections of round bar joined either by welding or drilling/tapping/bolting, depending on diameter. The parting and subsequent joining allows for the machining of axially-oriented side-drilled holes (SDHs) at prescribed metal travel



distances from the diameter of the bar. Normally two (2) or four (4) SDHs are used. SDH diameter is typically 1.0 mm (0.0394") or 3/64" (0.047"). Standard also contains three (3) FBHs (radially-oriented) at 1/4D, 1/2D, and 3/4D. FBH diameters are normally from 1/64" through 5/64", with 3/64" being most common. An axial EDM notch is often included in this design.



PWA SIS-315A; SIM-1 Standard

Pratt & Whitney Aircraft standard for round bar/rod inspection. Variation depicted at left shows standard containing one (1) 3/64" diameter FBH at 50% depth; one (1) 3/64" dia. at 10%; one 1/32" dia. at 10%; and one (1) axial EDM notch at 3% deep by 1/4" long.

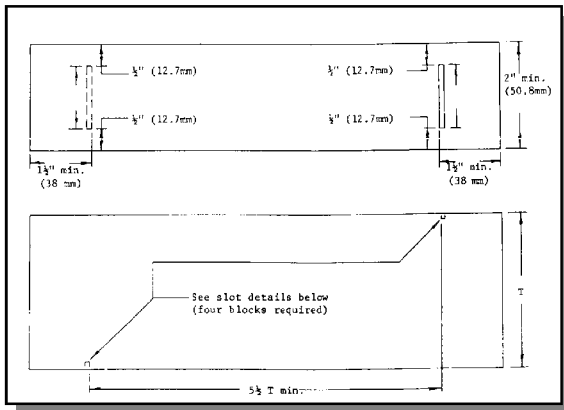
ULTRASONIC REFERENCE STANDARDS (OTHER)



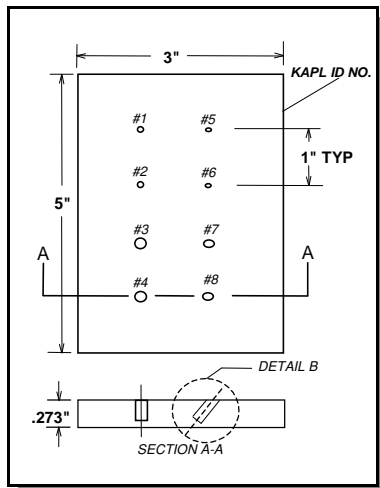
Projectile Body UT Standards

Typical projectile body and/or base standard will include OD and ID notches oriented both longitudinally and circumferentially. Notches can be uniformly deep across length, or thumbnail profile. Notch depth, width, length, and location are normally customer specified. Standards often contain FBHs also.

API RP 2X Reference Standard



American Petroleum Institute Reference Standard for Level "C" Examination for Recommended Practice 2X (RP 2X), *Ultrasonic Examination of Offshore Structural Fabrication and Guidelines for Qualification of Ultrasonic Technicians*. Set of four (4) blocks required. One block containing a square (buttress) notch and one each with V-notches for 45°, 60°, and 70° orientations for establishing scanning sensitivity for root reflectors. Note: Simulated references for rejectable flaws established by the Operator's UT specialist should be added to this block for the calibration of internal reflectors, i.e. 3/32" diameter side-drilled hole. In accordance with API RP 2X,



Miniature FBH Standard

Standard shown contains a total of eight (8) FBHs as follows: one (1) at .020" diameter with .100" clad depth (metal travel distance) oriented at 90° to the scanning surface, one (1) at .020" dia. x .050" clad at 90°, one (1) at .020" dia. x .100" clad at 45°, and one (1) at .020" dia. x .050" clad at 45°, and four (4) more same as above but at .060" diameter. Custom variations containing additional FBHs, other diameters, and different angles are available. Fax your sketch of any unique standard and we'll provide a prompt price quotation.



Remember, we routinely build Specials and Purpose-built Blocks for UT. If you need one block or 100, we can make it. And if your need is an Emergency, such as a plant outage or a grounded plane, our Rush service will get it to you when you need it.

PH TOOL
REFERENCE STANDARDS

www.phtool.com
email: sales@phtool.com

STANDARDS FOR IN-LINE PHASED ARRAY CALIBRATION SYSTEMS



Phased Array Calibration Standards

At PH Tool, our entire staff is dedicated to finding innovative ways to meet the demands of an increasingly-complex NDT marketplace.

Recently, PH Tool has been involved in supporting the commissioning of several in-line phased array bar and tube inspection systems. When the bar and tube industry adopted sophisticated phased array ultrasonic and eddy current technology to inspect their product, they turned to PH Tool to manufacture complex calibration standards.

In the wake of these new developments, PH Tool has pioneered a number of deep Flat-Bottom Hole (FBH) drilling and EDM notch machining techniques used in the manufacture of these longer/heavier calibration standards.

DEEP FLAT-BOTTOM HOLE DRILLING



FBH Calibration Standards

In past years, if a customer needed deep FBHs drilled, the standard needed to be "stepped," due to machine and tooling limitations.

Thanks to the experience and pioneering spirit of PH Tool, our customers can now calibrate on large-diameter standards that are not compromised with invasive steps or access pockets and slots.

To support this effort, we have added three vertical CNC mills dedicated to deep FBH drilling. The largest of the three has an incredible Z-axis travel of 41 inches. Combined with our specially-engineered tooling, PH Tool can now drill FBHs at 20 inches deep into a 21 inch diameter bar!

TECH SCALES



Tech Scales (Pack of 5)

You've seen them at our booth at trade shows over the years, now our handy NDT Technician scales are available for sale in packages of five scales. Made of sturdy, anodized aluminum, these great little scales are Inch on one side (0 to 8 inch in increments of .050, and .100), and Metric on the other (0 to 200 mm in 1 mm increments.) Dimensions: .063" thick x 8.0" (200mm) long.

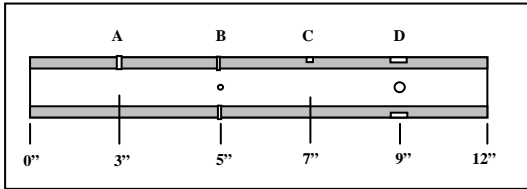


PH TOOL
REFERENCE STANDARDS

www.phtool.com
email: sales@phtool.com

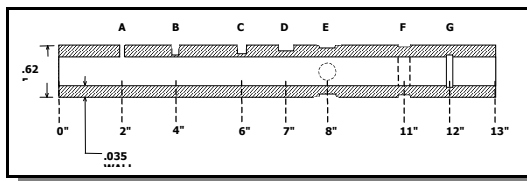
EDDY CURRENT CALIBRATION STANDARDS

ASME Sec. V Calibration Reference Standard 2007 Code

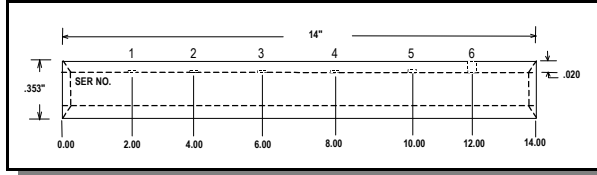


This standard is used to establish and verify system response for ET examination of nonferromagnetic steam generator heat exchanger tubing. Manufactured from tubing of the same nominal size and material type as that being examined. Discontinuities include one (1) through-wall hole (0.052" dia for tubing 3/4" and under; 0.067" dia for over 3/4"); four (4) through-wall holes @ .026" dia (for tubing 3/4" and under) or .033" dia (for tubing over 3/4") indexed 90°; one (1) 7/64" FBH @ 60%; and four (4) 3/16" FBHs @ 20% indexed 90°. Tubing can be customer or PH Tool-supplied. In accordance with 2007 ASME Section V, Article 8, Appendix II, Paragraph II-860.2.

ASME Sec. V Calibration Reference Standard Pre - 2007 Code

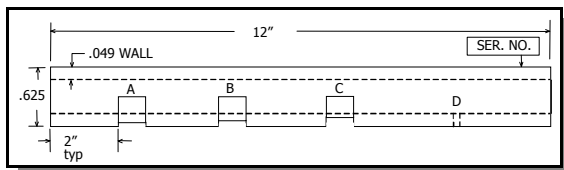


This standard is used to establish and verify system response for ET examination of nonferromagnetic steam generator heat exchanger tubing. Manufactured from tubing of the same nominal size and material type as that being examined. Discontinuities include one (1) through-wall hole (0.052" dia for tubing 3/4" and under; 0.067" dia for over 3/4"); one (1) 5/64" dia FBH @ 80% deep; one (1) 7/64" FBH @ 60%; one (1) 3/16" FBH @ 40%; four (4) 3/16" FBHs @ 20% indexed 90°; one (1) 1/8" wide 360° OD groove at 20% deep; and one (1) 1/16" wide 360° ID groove @ 10%. Tubing can be customer or PH Tool-supplied. In accordance with ASME Section V, Article 8, Appendix I, Paragraph I-865.



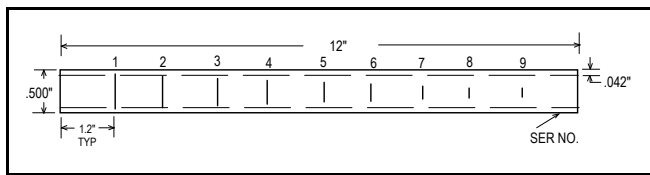
ID FBH Calibration Standard

Custom standard containing five (5) 0.010" diameter FBHs at varying depths from 0.002" to 0.006", and one (1) 0.010" diameter through-wall hole. FBH depth and location can be customer-directed. Typical separation between holes is 2".



180° 3-Flaw Wears-car Standard

Popular standard containing three (3) wearscars at 180° circumferential extent at depths (wall loss) of 25%, 50%, and 75% of wall thickness. 20%, 40%, 60% also popular. Extent of wearscar can be other than 180° if preferred. Standard also contains one (1) through-wall hole (0.052" dia. for tubing 3/4" and under; 0.067" dia. for tubing over 3/4". Circ extents of 120° and 360° also available.

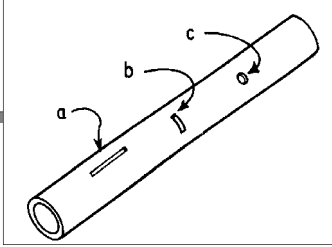


Circ Notch Eddy Current Standard

This standard contains nine (9) circumferentially-oriented OD EDM notches. All notches are 20% TWD (through-wall depth). Circumferential extent is 10° through 90° in 10° increments. Notch width is normally 0.005" to 0.010". Other variations are available.

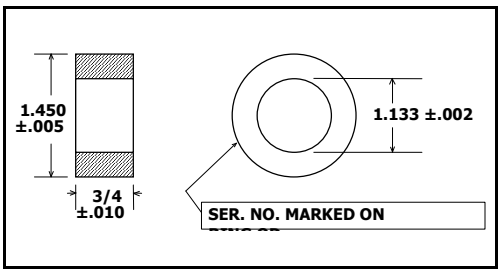
EDDY CURRENT CALIBRATION STANDARDS

ASME Section V Article 26 Eddy Current Standards



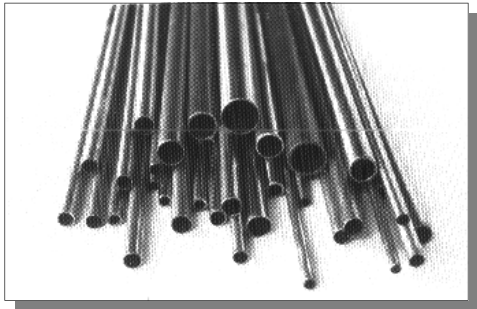
ASME Sec. V Art 26 ET Standards

All calibration and reference standards identified in Article 26 are available. Specifications include SE-215, SE-243, SE-309, SE-426, and SE-571. Inset shows SE-309, Figure 2, Various Types of Artificial Discontinuities, including longitudinal notch, transverse notch, and through-wall drilled hole.



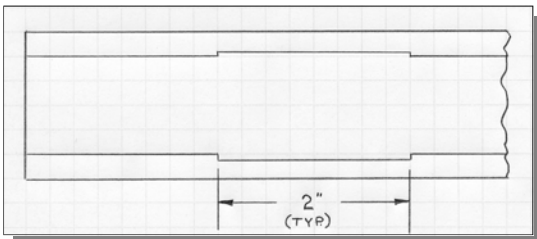
Tube Support Simulation Ring

Used with ASME and other eddy current calibration standards. ID of support ring fits OD of tube standard with approximately 0.010" clearance. Length of support ring typically varies from 1/4" to 1" depending on application. Available in many materials.



Specialized Tube Standards for ET

Custom variations are also available containing EDM notches, FBHs (OD and ID), wall thinning, simulated ID pitting, and other unusual discontinuities. Also includes standards of extra-long overall length, very small IDs, and exotic alloys such as tantalum and iridium. Send us your sketch of any unique standard and we'll provide a prompt price quotation.



ID Thinning Standard

Popular eddy current standard used to represent general uniform wastage (ID wall loss). Contains four (4) 2.0" long bands @ 10%, 20%, 30%, and 40% wall loss at 360° circumferential extent. Standard is made in two (2) 11" long pieces (22" overall) and is joined with a plastic coupling on the OD. Can be made in any tube alloy and size. Material is typically available from our stock with MTRs. If we don't stock it, we'll get it. Or, as always, this standard can be made from customer-supplied material.

PH TOOL
REFERENCE STANDARDS

www.phtool.com
email: sales@phtool.com

EDDY CURRENT CALIBRATION STANDARDS (OTHER)

3-Notch Surface Defect Calibration Std.

This common standard contains three (3) surface notches at depths of 0.008", 0.020", and 0.040". Notch width typically 0.004" to 0.005", with other widths possible. Optional notch #4 is a 0.030" by 0.030" 45° corner notch. (not pictured on sketch) Materials offered include 7075-T6 Aluminum, AISI 4340 Steel, Type 304 Stainless Steel, 6Al-4V Titanium, Inconel 600, Inconel 625, Inconel 690, and others. Notch depths are machine engraved on one edge; serial number and alloy on the other. NIST traceable. Block dims: 3.0" x 1.0" x .25". In accordance with PH Drawing No. 10075.



Bolthole Calibration Blocks

Common blocks containing bolthole notches. Notches can be oriented axially in hole, full thickness of block or less, 45° corner notches, thumbnail corner notches, or other. Block at left contains one (1) bolthole of .438" diameter with axial notch 0.030" deep x 0.004" wide x .030" long. Block dimensions: 2" diameter x .250" thick. Blocks with multiple holes and notches are common also. Typical hole diameters range from 0.125" to 1.000". Many different block thicknesses, overall sizes, and materials are available. Multiple layer blocks available.



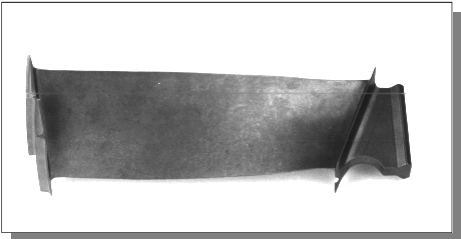
MIL-STD-271F Performance Verification Reference Block

The Performance Verification Reference Block meets the requirements of MIL-STD-271F, Paragraph 7.4.2. Block is approximately 4" x 6" x 3/8" thick and made of the same material type as that being inspected. Blocks normally contain four (4) notches machined to 0.015" deep x 0.250" long x 0.010" wide (maximum dimensions). Blocks used for inspection of welds in the as-welded condition contain a similar weld with notches positioned in the weld. PH Tool will supply the complete block, or machine the notches in customer-supplied welded blocks.



Turbine Blade Reference Standards

This standard is made from a customer-supplied blade of the same nominal composition as the blades being tested. EDM notches are machined on the leading and trailing edge of the convex and concave side. Notch dimensions per Westinghouse Process Specification 84351B4 are: 0.010" deep x 0.0025" wide x 0.250" long. Variations of this spec with additional notches are also available.

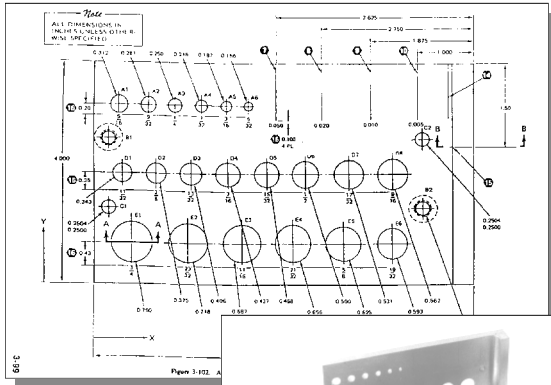


Wheel Inspection Reference Standards

This type of standard is made from a wheel of the same nominal composition and size as those being tested. EDM notches of various dimensions can be machined in high-stress areas of the wheel standard. Standards can be made from aircraft, truck, or automobile wheels. Wheels or wheel segments are customer-supplied.



EDDY CURRENT CALIBRATION STANDARDS (OTHER)



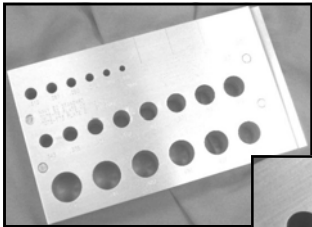
Air Force General Purpose Eddy Current Standard

Standard is a three (3) plate assembly measuring 4" x 7" x 1.06". Contains twenty (20) fastener holes with diameters from 0.156 to 0.750", two (2) screw holes, and two (2) dowel pins holes. Standard also contains a total of 66 EDM notches in various locations. Notch depth and length vary. Width is 0.004" for all notches. Material is Aluminum Alloy 7075-T6, QQ-A-250/12.

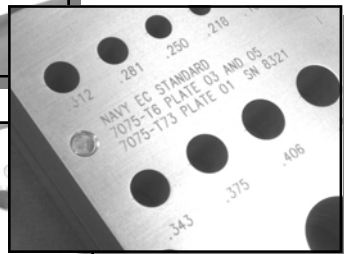
Finished standard is anodized per MIL-A-8625, Type II, Class I. Standard can also be made in titanium, steel, stainless steel or other alloy. Manufactured in accordance with U.S.A.F. Tech Order 33B-1-1, Figures 4-47 through 4-49. NSN 6635-01-092-5129, P/N 7947479-10.



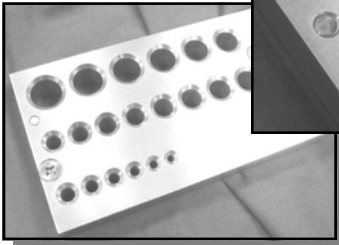
Top



Close-Up



Bottom



Navy Eddy Current Ref. Std. Kit (Universal Eddy Current Reference Std.)

Standard used by all AIMD NDI shops shorebased and shipboard intermediate maintenance activities for calibrating eddy current units prior to inspection. Standard is a three (3) plate assembly measuring 4" x 7" x .875". Contains twenty (20) fastener holes with diameters from 0.156 to 0.750", two (2) screw holes, and two (2) dowel pins holes. Standard also contains a total of 71 EDM notches in various locations. Notch depth and length vary. Width is 0.004" for all notches. Manufactured in accordance with U.S.A.F. Tech Order 33B-1-1, Figure 4-50. Kit P/N is NRK-3AST and consists of (1) Aluminum, P/N NRK-3A, 7075-T651 top and middle layer, 7075-T73 bottom layer; (1) Steel, P/N NRK-3S, 4340 alloy all three layers, and (1) Titanium, P/N NRK-3T, 6Al-4V alloy all three layers.

DC-10 Service Bulletin Reference Stds

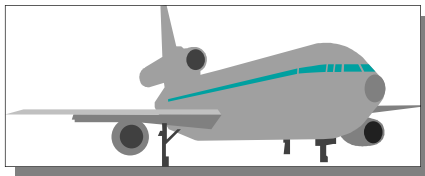
PH Tool is a recommended source for Eddy Current Reference Standards required per Service Bulletin 55-24. All four (4) standards are available including part numbers: SB10550024-3 (10RS.51), SB10550024-5 (10RS.51), SB10550024-7 (10RS.51), and SB09530016-5 (DAC GSET AL.01).



Aircraft Manufacturer Standards

Boeing, McDonnell Douglas, Airbus, Lockheed, Bombardier, Cessna, Saab, Gulfstream, Fairchild, others.

Standards are available to all aircraft manufacturer's specifications. We can manufacture the complete standard, or machine the EDM notches only in customer-supplied blanks. Both ET and UT standards offered.



PH TOOL
REFERENCE STANDARDS

www.phtool.com
email: sales@phtool.com

MAGNETIC PARTICLE STANDARDS



GE Compressor Blade Standard

This compressor blade standard is made from a customer-supplied blade similar to those being inspected. It contains seven (7) EDM slots (notches) located in the areas shown at left. Notch dimensions are 0.020" long x 0.005" and 0.010" deep x 0.0035" wide maximum. Notches are normally filled flush with a nonconducting material, such as epoxy, to prevent mechanical holding of the indicating medium.

In accordance with GE Power Generation Engineering Spec. P3C-AG16.



Ketos Ring

The Ketos Ring is used to check overall performance of the magnetic particle examination system. The Ketos Ring is 5" in diameter and .875" thick, with a 1-1/4" diameter center hole. The block includes (12) thru-holes at .070" diameter and distances of .140, .210, .280, .350, .420, .490, .560, .630, .700, .770, and .840" from the OD surface. Made from O-1 Tool Steel, and dimensionally certified to MIL-STD-1949A, ASTM E1444, McDonnell Douglas P.S. 21201, DPS 4.704, and SAE-AS5282.



"Flat Ketos" Block

Capable of indicating smaller subsurface discontinuities than its "ring-shaped" cousin, the "Flat Ketos" Block includes (12) thru-holes at .040" diameter, at distances of .060, .080, .100, .120, .160, and .200" from the upper indication surface, and at .240, .310, .390, .470, .550, and .630" from the lower indication surface. Also known as "Test Block with Artificial Subsurface Discontinuities." In accordance with PH Tool Drawing No. 10234. Metric Version also available. Made from O-1 Tool Steel (HRB 90-95).



ASTM E709 Magnetic Particle System Performance Verification Plate

Used to check the overall performance of wet or dry techniques using probes and yokes. This test plate contains ten (10) EDM notches 0.125" long x 0.005" through 0.050" deep x 0.005" wide. Material should be the same alloy as the material to be tested.

Plate measures 1" thick x 10" x 10". Notches are filled flush with a nonconducting material, such as epoxy, to prevent mechanical holding of the indicating medium. In accordance with ASTM E709, Figure 13.

MAGNETIC PARTICLE STANDARDS



MIL-STD-271F Magnetic Particle Test Plate

Used to verify system performance, this plate contains EDM notches oriented 90° to the magnetic flux. Notch dimensions are 0.063" long x 0.006" wide x 0.020" deep (maximum dimensions). Material is 3/8" thick low alloy steel plate of convenient size. Notches are normally filled flush with a nonconducting material, such as epoxy, to prevent mechanical holding of the indicating medium. Plate at left shows one (1) notch oriented parallel to the weld, and another perpendicular to the weld. In accordance with MIL-STD-271F (SHIPS), Paragraph 4.3.1.2.



Weight Lifting Gear Magnetic Particle Props

These standards will normally contain EDM notches of varying degree and severity. Notches can be machined in the high-stress areas including, the bight on both sides and in the throat, the shank, and the area below the shank. Notches are normally filled flush with a nonconducting material, such as epoxy, to prevent mechanical holding of the indicating medium. Hooks, shackles, pins, eyebolts, rings, etc., can be notched.

LIQUID PENETRANT STANDARDS



NSTR-99 Liquid Penetrant Personnel Qualification Test Props

These liquid penetrant test props contain at least four (4) micro-sized holes 0.004" to 0.005" diameter by 0.008" to 0.010" deep. Holes can be machined in welded plate, pipe, bolts, bevel canopies, c-canopies, socket welds, or any test prop. Materials can be customer-supplied or PH Tool-supplied. In accordance with U.S. Navy's NSTR-99 Rev. 3 (Qualification Examination Requirements for Nondestructive Test Personnel).

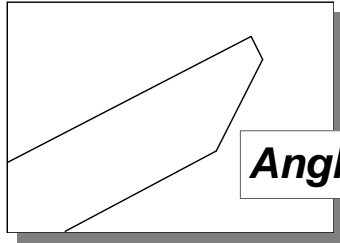


Liquid Penetrant Test Prop

Popular Navy LP prop consisting of a Stainless Steel plate with three (3) welds. Both the plate material and weld filler material are 300 series Stainless Steel. One weld is 1/32" reinforcement and is contoured (ground); the second is 1/16" reinforcement in the as-welded condition, the third is an as-welded root weld in a 90° V-groove. Plate contains twelve (12) micro-sized holes (NSTR-99) and one (1) linear indication (EDM notch). Notch is typically 0.250" long x 0.002 - 0.003" wide x 0.010 - 0.015" deep. Plate size is 5" x 7" x 1/2". Plates can be customer or PH Tool-supplied. Notches and holes of varying dimensions are also available. Certification Report with "as-built" hole and notch dimensions, and a map of defect locations.

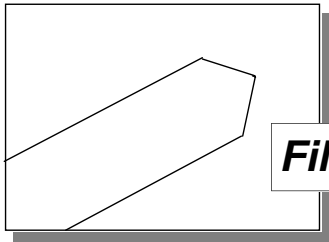
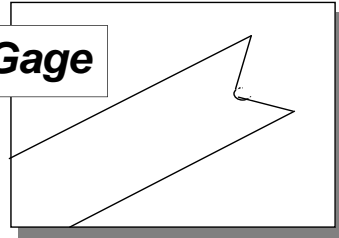
PRECISION DIMENSIONAL GAGES

PH Tool manufactures close-tolerance mechanical gages, examples of which appear below. Available in Tool Steel and other materials. These gages are custom made to your design. Send us a print of your special gage and we'll provide a prompt quote. High-precision machining methods enable us to maintain tolerances of "tenths". Gages are accurately measured and certified traceable to NIST using a high magnification video measurement system. Gages are laser-engraved with a unique serial number and as-built dimensions.



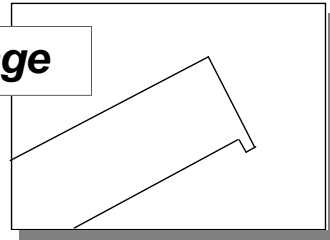
Angle Gage

Corner Radius Gage

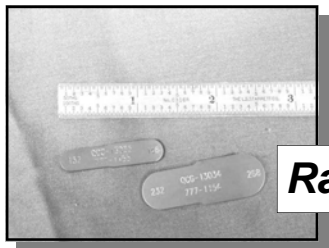
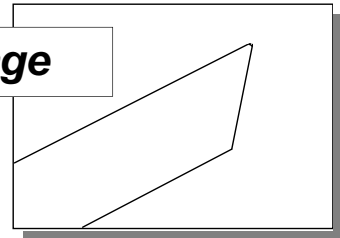


Fillet Radius Gage

Go No-Go Gage

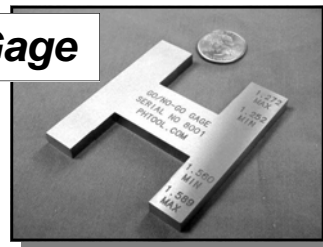


Fillet Angle Gage



Radius Gage

Stepped Min/Max Gage



SERVICES AVAILABLE



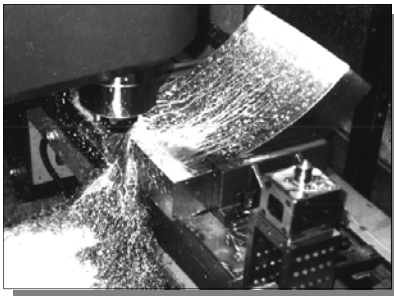
Sinker EDM

Electrical Discharge Machining (EDM) using Sinker or “Ram” machines has been our specialty since the 1970’s when this technology first became available to industry. As a pioneer in EDM, PH Tool quickly became known as the logical source for EDM Notch reference standards for the NDT community. Today, we have 13 Sinkers in our EDM Department ready to handle your notch requirements. All of our machines are purpose-built and allow us to accommodate any size standard from the smallest weighing only a few ounces to those exceeding 2 tons.



Wire EDM

EDM using Wire machines is another area of expertise for the company. This unique, non-conventional machining method allows the precise shaping of metals that cannot be machined any other way. Of the two wire EDMs we have in our EDM Department, one is especially large with table travels of 27” x 16” x 16” tall and is one of only 10 of its kind in service in the US. These machines can make complex shapes up to 16” tall including turbine disks, hubs, wheels, pipe sections of special size or heavy walls, dovetails, gears,



CNC Machining of Standards

PH Tool manufactures special test blocks and reference standards to customer specifications in our fully-equipped CNC machine shop. We are a full-capability manufacturer, from start to finish, so lead times are always reasonable. Our broad range of machining capabilities and expertise enables us to respond quickly to emergency or 24-hour Rush delivery requirements. We offer the complete package, including computer-aided design, CNC milling and EDM, drilling, turning, boring, grinding, video measuring, welding, cladding, and more. Variations of any standard in this catalog are available, including those required in special alloys.



CNC Milling

When we decided to expand our capabilities beyond EDM Notch standards into the manufacture of ultrasonic test blocks, eddy current standards, and magnetic particle/liquid penetrant standards, we knew that we’d need to invest in CNC machining centers. Today we have six CNC mills running every day making test blocks for NDT and peck drilling flat bottom holes (FBH).



Turning and Boring

Four lathes cover a wide range of capability up to 26” diameter turning. Our largest turret lathe has a through-hole measuring 6.250” and is tailored to machining UT bar and pipe standards requiring axial holes and the machining of weld preps for subsequent joining. Our CNC lathe is perfect for the complex turning of EDM notch blanks or special-purpose test blocks, bolthole standards, and more. Turning, boring, and facing is easily accomplished at PH Tool.

PH TOOL
REFERENCE STANDARDS

www.phtool.com
email: sales@phtool.com

SERVICES AVAILABLE



Surface Grinding

Ten surface grinders give us capacities that are unheard of in the NDT world. Our largest wet grinders are perfect for the incredibly accurate grinding of test blocks, while ensuring the exacting surface finishes that are expected in our industry. Beyond our normal range of grinders, we built a custom machine for grinding tall parts such as extra-long ASTM flat bottom hole reference blocks up to 48”.



Replication and Recertification to NIST

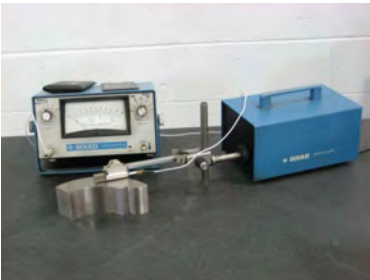
PH Tool offers replication (where applicable) and recertification services of existing standards. Standards of unknown origin, or those lacking certification, can be certified to the National Institute of Standards and Technology (NIST). Recertified standards are inspected using the same exacting methods and procedures as “new” standards. One of many calibrated devices used, our Video Measurement Systems provide accurate measurement of parts of all sizes within an 864 cubic inch working area. All standards are inspected using instruments calibrated in accordance with ISO 10012-1, ANSI/NCSL Z540-1, and MIL-STD-45662A using master gage blocks directly traceable to NIST. Quality Assurance Program complies with MIL-Q-9858A, 10CFR50 Appendix B, ANSI N45.2, ASME Section III Division 1, and MIL-I-45208. Inset at left shows a sample Certification Report, typical of one supplied with all standards. Refer to full-size sample cert in this catalog for clarity.

ITEM NO.	TYPE	DEFECTS	COMMENTS
1	U	NO DEFECTS	CONFORMS TO SPECIFICATION
2	U	NO DEFECTS	CONFORMS TO SPECIFICATION
3	U	NO DEFECTS	CONFORMS TO SPECIFICATION
4	U	NO DEFECTS	CONFORMS TO SPECIFICATION
5	U	NO DEFECTS	CONFORMS TO SPECIFICATION



Welding and Cladding

PH Tool offers both welding and cladding services. GTAW (Gas Tungsten Arc Welding), GMAW (Gas Metal Arc Welding), and SMAW (Shielded Metal Arc Welding) are available in many materials. Cladding of pipe and plate products for ASME calibration blocks, and welding of pipe or plate mockups and test props for UT, ET, PT and MT are routinely performed. Another popular application is the joining of two sections (butt-weld) of a Round Bar UT bar standard after machining the axial SDHs (side-drilled holes), and precisely re-attaching two halves of an Ultrasonic Cylinder standard after EDM of the ID reflectors.



Surface Roughness Measurement

Precise surface roughness measurements of machined standards are obtained using an electro-mechanical surface analyzer. Measurement of roughness is normally reported in R_a (Roughness Average in micro-inches), the universally recognized parameter of surface roughness. Standards can be manufactured to meet the surface roughness requirements of a particular testing application. We can also alter the surface finish of existing standards.



Electrical Conductivity Measurement

More and more customers are requesting that we report the actual Electrical Conductivity measurement (in % IACS) for the Eddy Current test standards we manufacture for them. Our Conductivity Meter allows us to accurately do just that. In addition to the alloy designation, and heat or lot number, we are now able to report conductivity on the Certification Report when requested.



www.phtool.com
email: sales@phtool.com

CERTIFICATION REPORT

CUSTOMER: **SAMPLE CO, INC.** DATE: **10/16/13**

SERIAL NO: **ABC970** ITEM: **EDDY CURRENT STANDARD** PO NO: **004123**

MATERIAL: **ALLOY 600** HEAT NO.: **NX5562HK9** SIZE: **.500" OD x .048" WALL x 48" LONG**

APPLICABLE SPECIFICATION: **CUSTOMER INSTRUCTION**

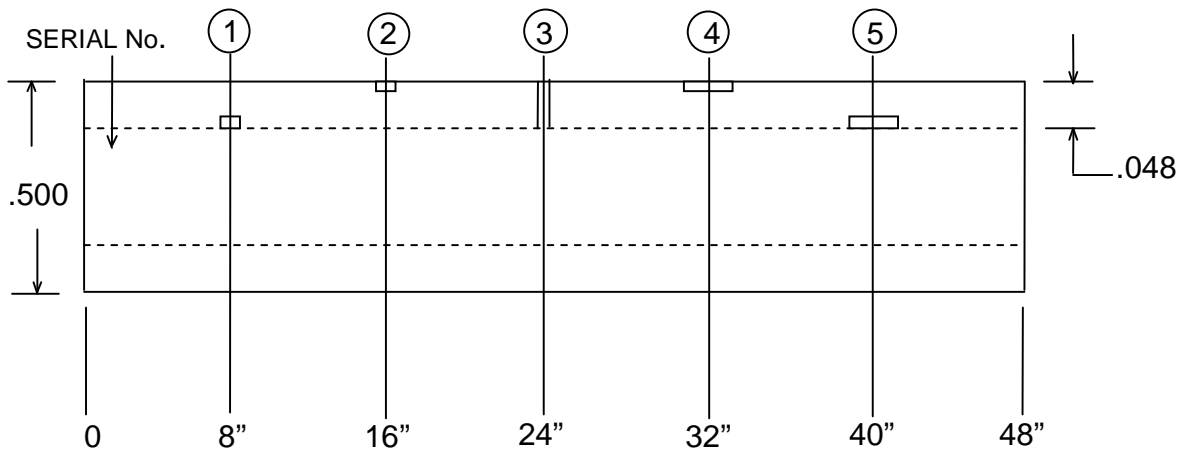
MEASURING TECHNIQUE USED:

XX REPLICATION
XX DIRECT MEASUREMENT
 OTHER

NIST TRACEABLE EQUIPMENT USED / TEST NO:

XX VIDEO MEASUREMENT SYS **821/262115-99**
DIAL INDICATOR **821/263248-00**
MICROMETER **821/263248-00**
XX GAGE BLOCKS **821/263248-00**

Manufactured in accordance with Quality Assurance Program Revision 1 dated 6/15/05 that complies with MIL-Q-9858A, 10CFR50 App B, ANSI N45.2, ASME Sec III Div 1 and MIL-I-45208A.



DIMENSIONS IN INCHES

DEFECT	TYPE	DEPTH	WIDTH	LENGTH	LOCATION	ORIENTATION
1	EDM NOTCH	0.0049	0.0390	0.0990	ID	TRANSVERSE
2	EDM NOTCH	0.0028	0.0050	0.0991	OD	TRANSVERSE
4	EDM NOTCH	0.0048	0.0393	0.0990	OD	LONGITUDINAL
5	EDM NOTCH	0.0029	0.0051	0.0990	ID	LONGITUDINAL
DEFECT	TYPE	DEPTH	DIAMETER			
3	EDM THRU-HOLE	THRU	0.0242			

IT IS CERTIFIED THAT THIS REFERENCE STANDARD HAS BEEN MANUFACTURED IN ACCORDANCE WITH APPLICABLE SPECIFICATIONS AND INSPECTED WITH INSTRUMENTS CALIBRATED IAW MIL-STD-45662 (LATEST REV.), ISO 10012-1 AND ANSI/NCSL Z540-1 USING MASTER GAGE BLOCKS AND MICRORULE MASTER SCALES DIRECTLY TRACEABLE TO THE NATIONAL INSTITUTE OF STANDARDS AND TECHNOLOGY (NIST).

SAMPLE ONLY

AUTHORIZED SIGNATURE _____
PHILIP R. HERMAN JR., QA MANAGER



6021 EASTON ROAD, PIPERSVILLE, PA 18947 USA
 T: 267-203-1600 · F: 267-203-1601 · www.phtool.com

This Certification Report shall not be reproduced except in full, without the written approval of PH TOOL.

Quick Fax

Rapid Response Form

To: **PH TOOL SALES DEPT.** Fax: **267-203-1601**

From: _____ Date: _____

Company: _____ Address: _____

Tel: _____ City/State: _____

Fax: _____ email: _____

RFQ - Request for Quotation

Please provide a quotation on the following item(s): (Describe standard below or attach sketch.)

RFI - Request for Information

Please provide information on the following item(s): (Describe standard below or attach sketch.)

Order

Describe item(s) you wish to order below or attach purchase order.

PO No.: _____ Need date: _____

Ship method: _____ Call to discuss? Yes ___ No ___

Other

ULTRASONIC TEST BLOCK PRICE LIST

PRICES EFFECTIVE: 1-1-2014 through 12-31-2014

FILE: test block price list 1-1-14.xls

Prices in US Dollars

email: sales@phtool.com

PH TOOL

6021 EASTON ROAD

PIPERSVILLE, PA 18947

PHONE: 267-203-1600

FAX: 267-203-1601

www.phtool.com

TEST BLOCK TYPE	ALLOY	LIST PRICE
IIW-TYPE 1	STEEL	437
IIW-TYPE 1	ALUM	437
IIW-TYPE 1	SS	767
IIW-TYPE 1	TITANIUM	Call
CASE		70
IIW-TYPE 1, METRIC	STEEL	501
IIW-TYPE 1, METRIC	ALUM	501
IIW-TYPE 1, METRIC	SS	882
IIW-TYPE 1, METRIC	TITANIUM	Call
CASE		70
IIW-TYPE 2	STEEL	509
IIW-TYPE 2	ALUM	509
IIW-TYPE 2	SS	892
IIW-TYPE 2	TITANIUM	Call
CASE		70
IIW-TYPE 2, METRIC	STEEL	585
IIW-TYPE 2, METRIC	ALUM	585
IIW-TYPE 2, METRIC	SS	1024
IIW-TYPE 2, METRIC	TITANIUM	Call
CASE		70
MINI IIW-TYPE 2, 1x2x6", Dwg. 10147	STEEL	509
MINI IIW-TYPE 2, 1x2x6", Dwg. 10147	ALUM	509
MINI IIW-TYPE 2, 1x2x6", Dwg. 10147	SS	892
MINI IIW-TYPE 2, 1x2x6", Dwg. 10147	TITANIUM	Call
CASE		51
MINI IIW-TYPE 2, METRIC, 25x50x150mm, Dwg. 10160	STEEL	585
MINI IIW-TYPE 2, METRIC, 25x50x150mm, Dwg. 10160	ALUM	585
MINI IIW-TYPE 2, METRIC, 25x50x150mm, Dwg. 10160	SS	1024
MINI IIW-TYPE 2, METRIC, 25x50x150mm, Dwg. 10160	TITANIUM	Call
CASE		51
PACS™ BLOCK	STEEL	1646
PACS™ BLOCK	ALUM	1646
PACS™ BLOCK	SS	2197
PACS™ BLOCK	TITANIUM	Call
CASE		98
MINI PACS™ BLOCK	STEEL	875
MINI PACS™ BLOCK	ALUM	875
MINI PACS™ BLOCK	SS	1167
MINI PACS™ BLOCK	TITANIUM	Call
CASE		63
PACS™ NOTCH BLOCK	STEEL	1927
PACS™ NOTCH BLOCK	ALUM	1927
PACS™ NOTCH BLOCK	SS	2605
PACS™ NOTCH BLOCK	TITANIUM	Call
CASE		57

ULTRASONIC TEST BLOCK PRICE LIST

PRICES EFFECTIVE: 1-1-2014 through 12-31-2014

FILE: test block price list 1-1-14.xls

Prices in US Dollars

email: sales@phtool.com

PH TOOL

6021 EASTON ROAD

PIPERSVILLE, PA 18947

PHONE: 267-203-1600

FAX: 267-203-1601

www.phtool.com

TEST BLOCK TYPE	ALLOY	LIST PRICE
ASTM E2491 PHASED ARRAY ASSESSMENT BLOCK, METRIC	STEEL	1670
ASTM E2491 PHASED ARRAY ASSESSMENT BLOCK, METRIC	ALUM	1210
ASTM E2491 PHASED ARRAY ASSESSMENT BLOCK, METRIC	SS	2337
ASTM E2491 PHASED ARRAY ASSESSMENT BLOCK, METRIC	TITANIUM	Call
CASE		67
ASTM E2491 PHASED ARRAY ASSESSMENT BLOCK, INCH	STEEL	1670
ASTM E2491 PHASED ARRAY ASSESSMENT BLOCK, INCH	ALUM	1210
ASTM E2491 PHASED ARRAY ASSESSMENT BLOCK, INCH	SS	2337
ASTM E2491 PHASED ARRAY ASSESSMENT BLOCK, INCH	TITANIUM	Call
CASE		67
PHASED ARRAY TYPE A BLOCK (IIW-TYPE), METRIC	STEEL	1510
PHASED ARRAY TYPE A BLOCK (IIW-TYPE), METRIC	ALUM	1510
PHASED ARRAY TYPE A BLOCK (IIW-TYPE), METRIC	SS	2037
PHASED ARRAY TYPE A BLOCK (IIW-TYPE), METRIC	TITANIUM	Call
CASE		70
PHASED ARRAY CALIBRATION BLOCK NO. 2	STEEL	909
PHASED ARRAY CALIBRATION BLOCK NO. 2	ALUM	909
PHASED ARRAY CALIBRATION BLOCK NO. 2	SS	1228
PHASED ARRAY CALIBRATION BLOCK NO. 2	TITANIUM	Call
CASE		76
DC BLOCK	STEEL	241
DC BLOCK	ALUM	241
DC BLOCK	SS	422
DC BLOCK	TITANIUM	Call
CASE		42
SC BLOCK	STEEL	242
SC BLOCK	ALUM	242
SC BLOCK	SS	424
SC BLOCK	TITANIUM	Call
CASE		37
DSC BLOCK	STEEL	318
DSC BLOCK	ALUM	318
DSC BLOCK	SS	558
DSC BLOCK	TITANIUM	Call
CASE		43
DSC BLOCK, METRIC	STEEL	366
DSC BLOCK, METRIC	ALUM	366
DSC BLOCK, METRIC	SS	642
DSC BLOCK, METRIC	TITANIUM	Call
CASE		43
DS BLOCK	STEEL	639
DS BLOCK	ALUM	639
DS BLOCK	SS	1116
DS BLOCK	TITANIUM	Call
CASE		106

ULTRASONIC TEST BLOCK PRICE LIST

PRICES EFFECTIVE: 1-1-2014 through 12-31-2014

FILE: test block price list 1-1-14.xls

Prices in US Dollars

email: sales@phtool.com

PH TOOL

6021 EASTON ROAD

PIPERSVILLE, PA 18947

PHONE: 267-203-1600

FAX: 267-203-1601

www.phtool.com

TEST BLOCK TYPE	ALLOY	LIST PRICE
4-STEP BLOCK, .250, .500, .750, 1.000"	STEEL	183
4-STEP BLOCK, .250, .500, .750, 1.000"	ALUM	183
4-STEP BLOCK, .250, .500, .750, 1.000"	SS	322
4-STEP BLOCK, .250, .500, .750, 1.000"	TITANIUM	Call
CASE		34
4-STEP BLOCK - METRIC 4A, 6.25, 12.50, 18.75, 25.00mm	STEEL	211
4-STEP BLOCK - METRIC 4A, 6.25, 12.50, 18.75, 25.00mm	ALUM	211
4-STEP BLOCK - METRIC 4A, 6.25, 12.50, 18.75, 25.00mm	SS	370
4-STEP BLOCK - METRIC 4A, 6.25, 12.50, 18.75, 25.00mm	TITANIUM	Call
CASE		34
4-STEP BLOCK - METRIC 4B, 5.0, 10.0, 15.0, 20.0mm	STEEL	211
4-STEP BLOCK - METRIC 4B, 5.0, 10.0, 15.0, 20.0mm	ALUM	211
4-STEP BLOCK - METRIC 4B, 5.0, 10.0, 15.0, 20.0mm	SS	370
4-STEP BLOCK - METRIC 4B, 5.0, 10.0, 15.0, 20.0mm	TITANIUM	Call
CASE		34
5-STEP BLOCK, .100, .200, .300, .400, .500"	STEEL	203
5-STEP BLOCK, .100, .200, .300, .400, .500"	ALUM	203
5-STEP BLOCK, .100, .200, .300, .400, .500"	SS	354
5-STEP BLOCK, .100, .200, .300, .400, .500"	TITANIUM	Call
CASE		34
5-STEP BLOCK - METRIC 5A, 2.5, 5.0, 7.5, 10.0, 12.5mm	STEEL	233
5-STEP BLOCK - METRIC 5A, 2.5, 5.0, 7.5, 10.0, 12.5mm	ALUM	233
5-STEP BLOCK - METRIC 5A, 2.5, 5.0, 7.5, 10.0, 12.5mm	SS	407
5-STEP BLOCK - METRIC 5A, 2.5, 5.0, 7.5, 10.0, 12.5mm	TITANIUM	Call
CASE		34
5-STEP BLOCK - METRIC 5B, 2.0, 4.0, 6.0, 8.0, 10.0mm	STEEL	233
5-STEP BLOCK - METRIC 5B, 2.0, 4.0, 6.0, 8.0, 10.0mm	ALUM	233
5-STEP BLOCK - METRIC 5B, 2.0, 4.0, 6.0, 8.0, 10.0mm	SS	407
5-STEP BLOCK - METRIC 5B, 2.0, 4.0, 6.0, 8.0, 10.0mm	TITANIUM	Call
CASE		34
10-STEP BLOCK, 0.1 to 1.0" x 0.1" Increments	STEEL	708
10-STEP BLOCK, 0.1 to 1.0" x 0.1" Increments	ALUM	708
10-STEP BLOCK, 0.1 to 1.0" x 0.1" Increments	SS	1239
10-STEP BLOCK, 0.1 to 1.0" x 0.1" Increments	TITANIUM	Call
CASE		57
10-STEP BLOCK - METRIC 10A, 2.5 to 25.0 x 2.5mm Increments	STEEL	815
10-STEP BLOCK - METRIC 10A, 2.5 to 25.0 x 2.5mm Increments	ALUM	815
10-STEP BLOCK - METRIC 10A, 2.5 to 25.0 x 2.5mm Increments	SS	1426
10-STEP BLOCK - METRIC 10A, 2.5 to 25.0 x 2.5mm Increments	TITANIUM	Call
CASE		57
10-STEP BLOCK - METRIC 10B, 2.0 to 20.0 x 2.0mm Increments	STEEL	815
10-STEP BLOCK - METRIC 10B, 2.0 to 20.0 x 2.0mm Increments	ALUM	815
10-STEP BLOCK - METRIC 10B, 2.0 to 20.0 x 2.0mm Increments	SS	1426
10-STEP BLOCK - METRIC 10B, 2.0 to 20.0 x 2.0mm Increments	TITANIUM	Call
CASE		57

ULTRASONIC TEST BLOCK PRICE LIST

PRICES EFFECTIVE: 1-1-2014 through 12-31-2014

FILE: test block price list 1-1-14.xls

Prices in US Dollars

email: sales@phtool.com

PH TOOL

6021 EASTON ROAD

PIPERSVILLE, PA 18947

PHONE: 267-203-1600

FAX: 267-203-1601

www.phtool.com

TEST BLOCK TYPE	ALLOY	LIST PRICE
THIN-STEP BLOCK - .040, .060, .080, .100"	STEEL	425
THIN-STEP BLOCK - .040, .060, .080, .100"	ALUM	425
THIN-STEP BLOCK - .040, .060, .080, .100"	SS	683
THIN-STEP BLOCK - .040, .060, .080, .100"	TITANIUM	Call
CASE		34
THIN-STEP BLOCK - METRIC, 1.0, 1.5, 2.0, 2.5mm	STEEL	489
THIN-STEP BLOCK - METRIC, 1.0, 1.5, 2.0, 2.5mm	ALUM	489
THIN-STEP BLOCK - METRIC, 1.0, 1.5, 2.0, 2.5mm	SS	785
THIN-STEP BLOCK - METRIC, 1.0, 1.5, 2.0, 2.5mm	TITANIUM	Call
CASE		34
MAGNA THIN-STEP BLOCK - .020, .040, .060, .080, .100"	STEEL	628
MAGNA THIN-STEP BLOCK - .020, .040, .060, .080, .100"	ALUM	628
MAGNA THIN-STEP BLOCK - .020, .040, .060, .080, .100"	SS	1040
MAGNA THIN-STEP BLOCK - .020, .040, .060, .080, .100"	TITANIUM	Call
CASE		34
MAGNA THIN-STEP BLOCK- METRIC, 0.5, 1.0, 1.5, 2.0, 2.5mm	STEEL	723
MAGNA THIN-STEP BLOCK- METRIC, 0.5, 1.0, 1.5, 2.0, 2.5mm	ALUM	723
MAGNA THIN-STEP BLOCK- METRIC, 0.5, 1.0, 1.5, 2.0, 2.5mm	SS	1196
MAGNA THIN-STEP BLOCK- METRIC, 0.5, 1.0, 1.5, 2.0, 2.5mm	TITANIUM	Call
CASE		34
TIPSY STEP BLOCK, 1.0 to 4.5" x .5" Increments	STEEL	601
TIPSY STEP BLOCK, 1.0 to 4.5" x .5" Increments	ALUM	601
TIPSY STEP BLOCK, 1.0 to 4.5" x .5" Increments	SS	961
TIPSY STEP BLOCK, 1.0 to 4.5" x .5" Increments	TITANIUM	Call
CASE		76
TIPSY STEP BLOCK - METRIC, 25 to 112.5, 12.5mm Increments	STEEL	691
TIPSY STEP BLOCK - METRIC, 25 to 112.5, 12.5mm Increments	ALUM	691
TIPSY STEP BLOCK - METRIC, 25 to 112.5, 12.5mm Increments	SS	1106
TIPSY STEP BLOCK - METRIC, 25 to 112.5, 12.5mm Increments	TITANIUM	Call
CASE		76
UNIVERSAL TIPSY BLOCK, 1.0 to 4.0" and 25mm to 100mm	STEEL	661
UNIVERSAL TIPSY BLOCK, 1.0 to 4.0" and 25mm to 100mm	ALUM	661
UNIVERSAL TIPSY BLOCK, 1.0 to 4.0" and 25mm to 100mm	SS	1055
UNIVERSAL TIPSY BLOCK, 1.0 to 4.0" and 25mm to 100mm	TITANIUM	Call
CASE		76
CURVED OD 5-STEP BLOCK - .100, .200, .300, .400, .500"	STEEL	372
CURVED OD 5-STEP BLOCK - .100, .200, .300, .400, .500"	ALUM	372
CURVED OD 5-STEP BLOCK - .100, .200, .300, .400, .500"	SS	651
CURVED OD 5-STEP BLOCK - .100, .200, .300, .400, .500"	TITANIUM	Call
CASE		41
EDM SLOT SIZING BLOCK - .100 to .900" x .100" Increments	STEEL	1151
EDM SLOT SIZING BLOCK - .100 to .900" x .100" Increments	ALUM	1151
EDM SLOT SIZING BLOCK - .100 to .900" x .100" Increments	SS	1911
CASE		73

ULTRASONIC TEST BLOCK PRICE LIST

PRICES EFFECTIVE: 1-1-2014 through 12-31-2014

FILE: test block price list 1-1-14.xls

Prices in US Dollars

email: sales@phtool.com

PH TOOL

6021 EASTON ROAD

PIPERSVILLE, PA 18947

PHONE: 267-203-1600

FAX: 267-203-1601

www.phtool.com

TEST BLOCK TYPE	ALLOY	LIST PRICE
DRILLED HOLE SIZING BLOCK - .100 to .900" x .100" Increments	STEEL	1001
DRILLED HOLE SIZING BLOCK - .100 to .900" x .100" Increments	ALUM	1001
DRILLED HOLE SIZING BLOCK - .100 to .900" x .100" Increments	SS	1636
CASE		73
"FAST" UT SIZING BLOCK, P/N 10072	STEEL	1263
CASE		73
TYPE MAB MINI ANGLE BEAM	STEEL	248
TYPE MAB MINI ANGLE BEAM	ALUM	248
TYPE MAB MINI ANGLE BEAM	SS	433
TYPE MAB MINI ANGLE BEAM	TITANIUM	Call
CASE		43
IOW BEAM PROFILE BLOCK, Inch or mm	STEEL	590
IOW BEAM PROFILE BLOCK, Inch or mm	ALUM	590
IOW BEAM PROFILE BLOCK, Inch or mm	SS	1032
IOW BEAM PROFILE BLOCK, Inch or mm	TITANIUM	Call
CASE		76
AWS RESOLUTION BLOCK	STEEL	262
AWS RESOLUTION BLOCK	ALUM	262
AWS RESOLUTION BLOCK	SS	461
AWS RESOLUTION BLOCK	TITANIUM	Call
CASE		48
NAVSHIPS TEST BLOCK	STEEL	446
NAVSHIPS TEST BLOCK	ALUM	446
NAVSHIPS TEST BLOCK	SS	778
NAVSHIPS TEST BLOCK	TITANIUM	Call
CASE		76
NAVSHIPS "3020" TEST BLOCK - NAVY TYPE	1018 STEEL	918
NAVSHIPS "3020" TEST BLOCK - NAVY TYPE	HY-80	1131
NAVSHIPS "3020" TEST BLOCK - NAVY TYPE	ALUM	918
NAVSHIPS "3020" TEST BLOCK - NAVY TYPE	SS	1627
NAVSHIPS "3020" TEST BLOCK - NAVY TYPE	TITANIUM	Call
CASE		76
PHASED ARRAY NAVSHIPS TEST BLOCK	STEEL	671
PHASED ARRAY NAVSHIPS TEST BLOCK	ALUM	671
PHASED ARRAY NAVSHIPS TEST BLOCK	SS	1177
PHASED ARRAY NAVSHIPS TEST BLOCK	TITANIUM	Call
CASE		76
MINI RESOLUTION BLOCK	STEEL	463
MINI RESOLUTION BLOCK	ALUM	463
MINI RESOLUTION BLOCK	SS	808
MINI RESOLUTION BLOCK	TITANIUM	Call
CASE		36
30 FBH RESOLUTION BLOCK	STEEL	2347
30 FBH RESOLUTION BLOCK	ALUM	2347
30 FBH RESOLUTION BLOCK	SS	4107
30 FBH RESOLUTION BLOCK	TITANIUM	Call
CASE		91

ULTRASONIC TEST BLOCK PRICE LIST

PRICES EFFECTIVE: 1-1-2014 through 12-31-2014

FILE: test block price list 1-1-14.xls

Prices in US Dollars

email: sales@phtool.com

PH TOOL

6021 EASTON ROAD

PIPERSVILLE, PA 18947

PHONE: 267-203-1600

FAX: 267-203-1601

www.phtool.com

TEST BLOCK TYPE	ALLOY	LIST PRICE
ASME N-625 REFERENCE PLATE	STEEL	702
ASME N-625 REFERENCE PLATE	ALUM	702
ASME N-625 REFERENCE PLATE	SS	1226
ASME N-625 REFERENCE PLATE	TITANIUM	Call
CASE		76
ASME SEC V BASIC CAL BLOCK (1/2"T)	STEEL	820
ASME SEC V BASIC CAL BLOCK (1/2"T)	ALUM	820
ASME SEC V BASIC CAL BLOCK (1/2"T)	SS	1108
CASE		76
ASME SEC V BASIC CAL BLOCK (1/2"T) - LONG VERSION	STEEL	1025
ASME SEC V BASIC CAL BLOCK (1/2"T) - LONG VERSION	ALUM	1025
ASME SEC V BASIC CAL BLOCK (1/2"T) - LONG VERSION	SS	1387
CASE		94
ASME SEC V BASIC CAL BLOCK (3/4"T)	STEEL	843
ASME SEC V BASIC CAL BLOCK (3/4"T)	ALUM	843
ASME SEC V BASIC CAL BLOCK (3/4"T)	SS	1136
CASE		76
ASME SEC V BASIC CAL BLOCK (3/4"T) - LONG VERSION	STEEL	1055
ASME SEC V BASIC CAL BLOCK (3/4"T) - LONG VERSION	ALUM	1055
ASME SEC V BASIC CAL BLOCK (3/4"T) - LONG VERSION	SS	1420
CASE		94
ASME SEC V BASIC CAL BLOCK (1 1/2"T)	STEEL	961
ASME SEC V BASIC CAL BLOCK (1 1/2"T)	ALUM	961
ASME SEC V BASIC CAL BLOCK (1 1/2"T)	SS	1319
CASE		98
ASME SEC V BASIC CAL BLOCK (1 1/2"T) - LONG VERSION	STEEL	1443
ASME SEC V BASIC CAL BLOCK (1 1/2"T) - LONG VERSION	ALUM	1443
ASME SEC V BASIC CAL BLOCK (1 1/2"T) - LONG VERSION	SS	1979
CASE		148
ASME SEC V BASIC CAL BLOCK (3"T)	STEEL	1222
ASME SEC V BASIC CAL BLOCK (3"T)	ALUM	1222
ASME SEC V BASIC CAL BLOCK (3"T)	SS	1780
CASE		206
ASME SEC V BASIC CAL BLOCK (3"T) - LONG VERSION	STEEL	2139
ASME SEC V BASIC CAL BLOCK (3"T) - LONG VERSION	ALUM	2139
ASME SEC V BASIC CAL BLOCK (3"T) - LONG VERSION	SS	3116
CASE		N/A
ASME SEC V BASIC CAL BLOCK (5"T)	STEEL	2334
ASME SEC V BASIC CAL BLOCK (5"T)	ALUM	2334
ASME SEC V BASIC CAL BLOCK (5"T)	SS	Call
CASE		N/A
ASTM AREA AMPLITUDE SET OF 8	STEEL	1946
ASTM AREA AMPLITUDE SET OF 8	ALUM	2226
ASTM AREA AMPLITUDE SET OF 8	SS	3091
ASTM AREA AMPLITUDE SET OF 8	TITANIUM	Call
CASE		122
ASTM DISTANCE/AREA AMPL. SET OF 10	STEEL	2219
ASTM DISTANCE/AREA AMPL. SET OF 10	ALUM	2663
ASTM DISTANCE/AREA AMPL. SET OF 10	SS	3541
ASTM DISTANCE/AREA AMPL. SET OF 10	TITANIUM	Call
CASE		128

ULTRASONIC TEST BLOCK PRICE LIST

PRICES EFFECTIVE: 1-1-2014 through 12-31-2014

FILE: test block price list 1-1-14.xls

Prices in US Dollars

email: sales@phtool.com

PH TOOL

6021 EASTON ROAD

PIPERSVILLE, PA 18947

PHONE: 267-203-1600

FAX: 267-203-1601

www.phtool.com

TEST BLOCK TYPE	ALLOY	LIST PRICE
ASTM DISTANCE AMPLITUDE SET OF 19, #3/5/8	STEEL	4022
ASTM DISTANCE AMPLITUDE SET OF 19, #3/5/8	ALUM	4651
ASTM DISTANCE AMPLITUDE SET OF 19, #3/5/8	SS	6350
ASTM DISTANCE AMPLITUDE SET OF 19, #3/5/8	TITANIUM	Call
CASE		206
V1/5 (A2) TEST BLOCK (BS2704)	STEEL	608
V1/5 (A2) TEST BLOCK (BS2704)	ALUM	608
V1/5 (A2) TEST BLOCK (BS2704)	SS	1041
V1/5 (A2) TEST BLOCK (BS2704)	TITANIUM	Call
CASE		70
V2 (A4) 12.5, 20, and 25mm TEST BLOCK	STEEL	378
V2 (A4) 12.5, 20, and 25mm TEST BLOCK	ALUM	378
V2 (A4) 12.5, 20, and 25mm TEST BLOCK	SS	642
V2 (A4) 12.5, 20, and 25mm TEST BLOCK	TITANIUM	Call
CASE		43
CALIBRATION BLOCK No. 1 (K1) (EN12223 / ISO2400)	STEEL	608
CALIBRATION BLOCK No. 1 (K1) (EN12223 / ISO2400)	ALUM	608
CALIBRATION BLOCK No. 1 (K1) (EN12223 / ISO2400)	SS	1041
CALIBRATION BLOCK No. 1 (K1) (EN12223 / ISO2400)	TITANIUM	Call
CASE		70
CALIBRATION BLOCK No. 2 (12.5, 20, and 25mm)	STEEL	378
CALIBRATION BLOCK No. 2 (12.5, 20, and 25mm)	ALUM	378
CALIBRATION BLOCK No. 2 (12.5, 20, and 25mm)	SS	642
CALIBRATION BLOCK No. 2 (12.5, 20, and 25mm)	TITANIUM	Call
CASE		43
VW STEP BLOCK, 1-8mm STEPS	STEEL	634
VW STEP BLOCK, 1-8mm STEPS	ALUM	746
VW STEP BLOCK, 1-8mm STEPS	303 SS	808
VW STEP BLOCK, 1-8mm STEPS	TITANIUM	Call
CASE		34
ASTM E317 RESOLUTION BLOCK, FIG. 1	STEEL	542
ASTM E317 RESOLUTION BLOCK, FIG. 1	ALUM	542
ASTM E317 RESOLUTION BLOCK, FIG. 1	SS	950
CASE		59
ASTM E317 RESOLUTION BLOCK, FIG. 6, #3 FBHs	STEEL	1646
ASTM E317 RESOLUTION BLOCK, FIG. 6, #3 FBHs	ALUM	1646
ASTM E317 RESOLUTION BLOCK, FIG. 6, #3 FBHs	SS	2880
CASE		89
ASTM E317 RESOLUTION BLOCK, FIG. 6, #1 FBHs	STEEL	1903
ASTM E317 RESOLUTION BLOCK, FIG. 6, #1 FBHs	ALUM	1903
ASTM E317 RESOLUTION BLOCK, FIG. 6, #1 FBHs	SS	3330
CASE		89

NOTES:

- METRIC BLOCKS NOT SEPARATELY PRICED MUST ADD 15% TO IMPERIAL (INCH) PRICING.
(does not apply to IOW, V1, V2, VW, or ISO 7963 Blocks)
- ALL OTHER STANDARDS IN THIS CATALOG, INCLUDING SPECIAL TEST BLOCKS, ARE QUOTED INDIVIDUALLY.
- ASTM SET OF 19 WITH #1 FBH ADDS 35% TO PRICE.
- ASTM SET OF 19 WITH #2 FBH ADDS 15% TO PRICE.
- PRICES ARE SUBJECT TO CHANGE WITHOUT NOTICE.

DIMENSIONAL INSPECTION PRICE LIST

ULTRASONIC & EDDY CURRENT TEST BLOCKS
 PRICES EFFECTIVE: 1-1-2014 through 12-31-2014

FILE: dimension inspection price list 1-1-14.xls
 Prices in US Dollars
 email: sales@phtool.com

PH TOOL

6021 EASTON ROAD
 PIPERSVILLE, PA 18947
 PHONE: 267-203-1600
 FAX: 267-203-1601
 www.phtool.com

TEST BLOCK TYPE	LIST PRICE FOR DIMENSIONAL INSPECTION
IIW-TYPE 1	151
IIW-TYPE 2	177
MINI IIW-TYPE 2	151
PACS BLOCK	195
PA TYPE A BLOCK (IIW-TYPE)	387
DC BLOCK	93
SC BLOCK	79
DSC BLOCK	131
DS BLOCK	216
4-STEP BLOCK	68
5-STEP BLOCK	73
10-STEP BLOCK	141
THIN-STEP BLOCK	68
TIPSY STEP BLOCK	131
TYPE MAB MINI ANGLE BEAM	93
IOW BEAM PROFILE BLOCK	190
AWS RESOLUTION BLOCK	93
NAVSHIPS TEST BLOCK	151
MINI RESOLUTION BLOCK	131
30 FBH RESOLUTION BLOCK	N/A
ASME N-625 REFERENCE PLATE	190
ASME SEC V BASIC CAL BLOCK (1/2" T)	290
ASME SEC V BASIC CAL BLOCK (3/4" T)	290
ASME SEC V BASIC CAL BLOCK (1 1/2" T)	316
ASME SEC V BASIC CAL BLOCK (3" T)	383
ASTM AREA/AMPLITUDE SET OF 8 - Steel & SS	579
ASTM AREA/AMPLITUDE SET OF 8 - Alum	685
ASTM DISTANCE/AREA AMPL. SET OF 10 - Steel & SS	724
ASTM DISTANCE/AREA AMPL. SET OF 10 - Alum	855
ASTM DISTANCE/AMPLITUDE SET OF 19 - Steel & SS	1376
ASTM DISTANCE/AMPLITUDE SET OF 19 - Alum	1625
SINGLE ASTM BLOCK, UT CERT TO E127 (BALL TO BLOCK METHOD)	211
SINGLE ASTM BLOCK, DIMENSIONAL INSP. ONLY (2" dia up to 6.75")	101
ASTM DISTANCE/AMPLITUDE SET OF 12 - Alum - 2" Dia	1018
ASTM DISTANCE/AMPLITUDE SET OF 12 - Alum - 4" Dia	1453
V1/5 (A2) TEST BLOCK	177
V2 (25mm) TEST BLOCK	146
VW STEP BLOCK, 1-8mm STEPS	131
ASME ANGLE BEAM CAL STANDARD, 4 EDM NOTCHES	528
USAF or NAVY EC STANDARD	1283
ASTM E317 FIG. 1	199
ASTM E317 FIG. 6	421
3-NOTCH EDDY CURRENT STANDARD	231

DIMENSIONAL CERTIFICATION INCLUDES CERT WITH AS-BUILTS.
 ASTM SET CERTIFICATION IS NOT DIMENSIONAL; UT PLOTS ONLY.
 MINIMUM LOT CHARGE FOR DIMENSIONAL INSPECTION IS \$100. TRY TO COMBINE ITEMS.
 ABOVE SERVICES AT TIME BLOCK IS ORDERED ARE 50% OFF.
 PRICES ARE SUBJECT TO CHANGE WITHOUT NOTICE.

Reference Standards and Calibration Blocks for the NDT Industry



PH TOOL
REFERENCE STANDARDS

Phil Herman

President/CEO
phil@phtool.com
267-203-1600, ext. 114

Rob Gormley

Sales Manager
rob@phtool.com
267-203-1600, ext. 109

Pam Martin

Operations Manager
pam@phtool.com
267-203-1600, ext. 103

Andrew Robinson

Sales Estimator
andrew@phtool.com
267-203-1600, ext. 108

Buy Online...www.phtool.com

Reference Standards
and
Calibration Blocks
for the
NDT Industry



PH **TOOL**
REFERENCE STANDARDS
PH **TOOL**

The STANDARD of Excellence

6021 Easton Road • Pipersville, PA 18947 • USA
267-203-1600 • Fax: 267-203-1601 • sales@phtool.com
Buy online...www.phtool.com